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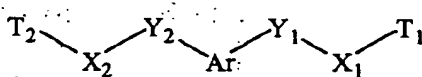
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(54) **Organophotoreceptor with charge transport material having a thiiranyl group**

(57) The present invention provides organophotoreceptors comprising a photoconductive element comprising:

(a) a charge transport material having the formula



where Y_1 and Y_2 are, each independently, a bond, $-\text{CR}_1=\text{N}-\text{NR}_2-$, or $-\text{CR}_3=\text{N}=\text{CR}_4-$ where R_1 , R_2 , R_3 , and R_4 comprise, each independently, H, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

X_1 and X_2 are, each independently, a linking

group;

T_1 and T_2 are, each independently, a thiiranyl group, H, an alkyl group, an alkenyl group, or an aromatic group with the proviso that at least one of T_1 and T_2 is a thiiranyl group; and

Ar comprises an aromatic group with the proviso that when both Y_1 and Y_2 are a bond and one of T_1 and T_2 is not a thiiranyl group, Ar comprises a bis[(N,N-disubstituted)amino]aromatic group or a bicarbazole group; and

(b) a charge generating compound.

Corresponding electrophotographic apparatuses and imaging methods (processes) are described, as are corresponding charge transport materials.

Description

[0001] This invention relates to organophotoreceptors suitable for use in electrophotography and, more specifically, to organophotoreceptors having a charge transport material comprising at least a thiiranyl group. The thiiranyl group (s) may or may not be covalently bonded with a polymeric binder, directly or through a crosslinking compound.

[0002] In electrophotography, an organophotoreceptor in the form of a plate, disk, sheet, belt, drum or the like having an electrically insulating photoconductive element on an electrically conductive substrate is imaged by first uniformly electrostatically charging the surface of the photoconductive layer, and then exposing the charged surface to a pattern of light. The light exposure selectively dissipates the charge in the illuminated areas where light strikes the surface, thereby forming a pattern of charged and uncharged areas, referred to as a latent image. A liquid or dry toner is then provided in the vicinity of the latent image, and toner droplets or particles deposit in the vicinity of either the charged or uncharged areas to create a toned image on the surface of the photoconductive layer. The resulting toned image can be transferred to a suitable ultimate or intermediate receiving surface, such as paper, or the photoconductive layer can operate as an ultimate receptor for the image. The imaging process can be repeated many times to complete a single image, for example, by overlaying images of distinct color components or effect shadow images, such as overlaying images of distinct colors to form a full color final image, and/or to reproduce additional images.

[0003] Both single layer and multilayer photoconductive elements have been used. In single layer embodiments, a charge transport material and charge generating material are combined with a polymeric binder and then deposited on the electrically conductive substrate. In multilayer embodiments, the charge transport material and charge generating material are present in the element in separate layers, each of which can optionally be combined with a polymeric binder, deposited on the electrically conductive substrate. Two arrangements are possible for a two-layer photoconductive element. In one two-layer arrangement (the "dual layer" arrangement), the charge-generating layer is deposited on the electrically conductive substrate and the charge transport layer is deposited on top of the charge generating layer. In an alternate two-layer arrangement (the "inverted dual layer" arrangement), the order of the charge transport layer and charge generating layer is reversed.

[0004] In both the single and multilayer photoconductive elements, the purpose of the charge generating material is to generate charge carriers (i.e., holes and/or electrons) upon exposure to light. The purpose of the charge transport material is to accept at least one type of these charge carriers and transport them through the charge transport layer in order to facilitate discharge of a surface charge on the photoconductive element. The charge transport material can be a charge transport compound, an electron transport compound, or a combination of both. When a charge transport compound is used, the charge transport compound accepts the hole carriers and transports them through the layer with the charge transport compound. When an electron transport compound is used, the electron transport compound accepts the electron carriers and transports them through the layer with the electron transport compound.

[0005] Organophotoreceptors may be used for both dry and liquid electrophotography. There are many differences between dry and liquid electrophotography. The most obvious difference is that a dry toner is used in dry electrophotography, whereas a liquid toner is used in liquid electrophotography. A potential advantage of liquid electrophotography is that it can provide an improved resolution and thus sharper images than dry electrophotography because liquid toner particles can generally be significantly smaller than dry toner particles. As a result of their smaller size, liquid toners are able to provide images of higher optical density per toner mass.

[0006] In both dry and liquid electrophotography, the charge transport material used for the organophotoreceptor is required to be compatible with the polymeric binder in the photoconductive element. The requirement puts an undesirable limitation in choosing a suitable polymeric binder for a particular charge transport material. If the charge transport material is not compatible with the polymeric binder, the charge transport material may phase-separate or crystallize in the polymeric binder matrix, or may diffuse onto the surface of the layer containing the charge transport material. If such incompatibility occurs, the organophotoreceptor may cease to transport charge.

[0007] Furthermore, liquid electrophotography faces an additional problem. The problem is that the organophotoreceptor for liquid electrophotography is in frequent contact with the liquid carrier of a liquid toner. As a result, the charge transport material in the photoconductive element may be removed by constant extraction by the liquid carrier. Over a long period of operation, the amount of the charge transport material removed by extraction may be significant, and such removal may be detrimental to the performance of the organophotoreceptor.

[0008] Although many charge transport materials are known, there is the need for other charge transport materials to meet the various requirements of particular electrophotographic applications.

[0009] To produce high quality images, particularly after multiple cycles, it is desirable for the charge transport materials to form a homogeneous solution with the polymeric binder and remain approximately homogeneously distributed through the organophotoreceptor material during the cycling of the material. In addition, it is desirable to increase the amount of charge that the charge transport material can accept (indicated by a parameter known as the acceptance voltage or " V_{acc} "), and to reduce retention of that charge upon discharge (indicated by a parameter known as the discharge voltage or " V_{dis} ").

[0010] An aim of the present invention is to provide organophotoreceptors, electrophotographic imaging apparatus, electrophotographic imaging processes, and charge transport materials, preferably generally featuring (a) good, and/or beneficial, and/or useful propert(y)ies, or combinations of such properties, and preferably addressing at least one or some of the problems in the art.

[0011] There are many charge transport materials available for electrophotography, including, for example, pyrazoline derivatives, fluorene derivatives, oxadiazole derivatives, stilbene derivatives, hydrazone derivatives, carbazole hydrazone derivatives, triaryl amines, polyvinyl carbazole, polyvinyl pyrene, and polyacenaphthylene. However, at least some of the available charge transport materials may suffer some disadvantages and thus there is always the need for charge transport materials to meet the various requirements of electrophotography applications. This represents a further preferred aim of the present invention.

[0012] A preferred aim of the present invention is to provide organophotoreceptors having good electrostatic properties.

[0013] Moreover, a further preferred aim of the present invention is to provide charge transport materials for organophotoreceptors featuring good mechanical and/or chemical properties, and/or a combination of good mechanical and electrostatic properties.

[0014] Suitably, a further aim of embodiments of the present invention is to provide organophotoreceptors and electrophotographic imaging apparatus which can be used to provide high quality of images, even after repeated cycling, electrophotographic apparatus employing the organophotoreceptors and electrophotographic imaging methods using the organophotoreceptors/charge transport materials.

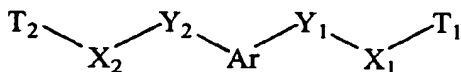
[0015] Other aims and/or advantages of the invention will be set forth in part in the description which follows and, in part, will be apparent or obvious from the description, or may be apparent from, or learned by, practice of the invention.

[0016] According to the present invention there is provided an organophotoreceptor, an electrophotographic imaging apparatus, an electrophotographic imaging process, a charge transport material, and a polymeric charge transport material, as set forth in the appended claims. Preferred features of the invention will be apparent from the dependent claims, and the description which follows.

[0017] Accordingly, this invention seeks to provide organophotoreceptors having good electrostatic properties such as high V_{acc} and low V_{dis} . This invention also seeks to provide charge transport materials having a high compatibility with the polymeric binder, minimal phase separation, and minimal extraction by liquid carriers.

[0018] In a first aspect of the present invention there is provided an organophotoreceptor comprising an electrically conductive substrate and a photoconductive element on the electrically conductive substrate, the photoconductive element comprising:

(a) a charge transport material having the formula



where Y_1 and Y_2 are, each independently, a bond, $-CR_1=N-NR_2-$, or $-CR_3=N=N-CR_4-$ where R_1 , R_2 , R_3 , and R_4 comprise, each independently, H, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

X_1 and X_2 are, each independently, a linking group having the formula $-(CH_2)_m-$, branched or linear, where m is an integer between 0 and 20, inclusive, and one or more of the methylene groups is optionally replaced by O, S, C=O, O=S=O, a heterocyclic group, an aromatic group, urethane, urea, an ester group, an NR_5 group, a CHR_6 group, or a CR_7R_8 group where R_5 , R_6 , R_7 , and R_8 comprise, each independently, H, hydroxyl group, thiol group, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

T_1 and T_2 are, each independently, a thiiranyl group, H, an alkyl group, an alkenyl group, or an aromatic group with the proviso that at least one of T_1 and T_2 is a thiiranyl group; and

Ar comprises an aromatic group with the proviso that when both Y_1 and Y_2 are a bond and one of T_1 and T_2 is not a thiiranyl group, Ar comprises a bis[(N,N-disubstituted)amino]aromatic group or a bicarbazole group; and

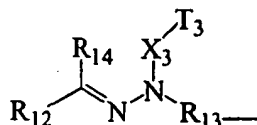
(b) a charge generating compound.

[0019] Preferably, T_2 is H, the m value for X_2 is 0, Y_2 is a bond, Y_1 is $-CR_1=N-NR_2-$ where the C atom is connected to Ar and the terminal N atom is connected to X_1 , and T_1 comprises a thiiranyl group.

[0020] Preferably, Ar comprises an arylamine group or an aromatic heterocyclic group.

[0021] Preferably, R_2 comprises an aromatic group.

[0022] Preferably, the aromatic group of R_2 has the formula



where R_{12} comprises an arylamine group, R_{13} is a linking group comprising an alkyl group, an alkenyl group, or an aryl group, R_{14} comprises H, an alkyl group, an alkenyl group, or an aryl group, X_3 has the formula $-(CH_2)_m-$, branched or linear, where m is an integer between 1 and 20, and T_3 is a thiiranyl group.

[0023] Preferably, the m value for X_1 is 0, T_1 comprises an aromatic group, T_2 comprises a thiiranyl group, Y_2 is a bond, and Y_1 is $-CR_1=N-NR_2-$ where the C atom is connected to Ar and the terminal N atom is connected directly to T_1 .

[0024] Preferably, T_2 is H, the m value for X_2 is 0, Y_2 is a bond, Y_1 is $-CR_3=N-N=CR_4-$, and T_1 comprises a thiiranyl group.

[0025] Preferably, Y_1 and Y_2 are a bond and Ar comprises a bis[(N,N-disubstituted)amino]arylene group.

[0026] Preferably, T_2 is H, an alkyl group, an alkenyl group, or an aromatic group.

[0027] Preferably, Y_1 and Y_2 are a bond, Ar comprises two arylamine groups.

[0028] Preferably, Ar is a bicarbazole group.

[0029] Preferably, Ar comprises an arylamine group, Y_1 and Y_2 are each independently $-CR_1=N-NR_2-$, and T_1 and T_2 , each independently, comprise a thiiranyl group.

[0030] Preferably, the photoconductive element further comprises a second charge transport material.

[0031] Preferably, the second charge transport material comprises an electron transport compound.

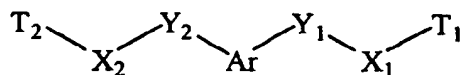
[0032] Preferably, the photoconductive element further comprises a binder.

[0033] The organophotoreceptor may be provided, for example, in the form of a plate, a flexible belt, a flexible disk, a sheet, a rigid drum, or a sheet around a rigid or compliant drum. In one embodiment, the organophotoreceptor includes: (a) a photoconductive element comprising the charge transport material, the charge generating compound, a second charge transport material, and a polymeric binder; and (b) the electrically conductive substrate.

[0034] In a second aspect of the present invention there is provided an electrophotographic imaging apparatus that comprises (a) a light imaging component; and (b) the organophotoreceptor described herein oriented to receive light from the light imaging component. The apparatus can further comprise a liquid toner dispenser. The method of electrophotographic imaging with photoreceptors containing the above noted charge transport materials is also described.

[0035] In a third aspect of the present invention there is provided an electrophotographic imaging process that includes (a) applying an electrical charge to a surface of the organophotoreceptor described herein; (b) imagewise exposing the surface of the organophotoreceptor to radiation to dissipate charge in selected areas and thereby form a pattern of at least relatively charged and uncharged areas on the surface; (c) contacting the surface with a toner, such as a liquid toner that includes a dispersion of colorant particles in an organic liquid, to create a toned image; and (d) transferring the toned image to a substrate.

[0036] In a fourth aspect of the present invention there is provided a charge transport material having the general formula above, i.e. the formula



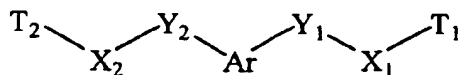
where Y_1 and Y_2 are, each independently, a bond, $-CR_1=N-NR_2-$, or $-CR_3=N-N=CR_4-$ where R_1 , R_2 , R_3 , and R_4 comprise, each independently, H, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

X_1 and X_2 are, each independently, a linking group having the formula $-(CH_2)_m-$, branched or linear, where m is an integer between 0 and 20, inclusive, and one or more of the methylene groups is optionally replaced by O, S, C=O, O=S=O, a heterocyclic group, an aromatic group, urethane, urea, an ester group, an NR_5 group, a CHR_6 group, or a CR_7R_8 group where R_5 , R_6 , R_7 , and R_8 comprise, each independently, H, hydroxyl group, thiol group, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

T_1 and T_2 are, each independently, a thiiranyl group, H, an alkyl group, an alkenyl group, or an aromatic group with the proviso that at least one of T_1 and T_2 is a thiiranyl group; and

Ar comprises an aromatic group with the proviso that when both Y_1 and Y_2 are a bond and one of T_1 and T_2 is not a thiiranyl group, Ar comprises a bis[(N,N-disubstituted)amino]aromatic group or a bicarbazole group.

[0037] In a fifth aspect of the present invention there is provided a polymeric charge transport compound prepared by the reaction of a functional group in a polymeric binder with at least a thiiranyl group in a compound having the formula



where Y_1 and Y_2 are, each independently, a bond, $-\text{CR}_1=\text{N}-\text{NR}_2-$, or $-\text{CR}_3=\text{N}=\text{N}=\text{CR}_4-$ where R_1 , R_2 , R_3 , and R_4 comprise, each independently, H, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

X_1 and X_2 are, each independently, a linking group having the formula $-(\text{CH}_2)_m-$, branched or linear, where m is an integer between 0 and 20, inclusive, and one or more of the methylene groups is optionally replaced by O, S, C=O, O=S=O, a heterocyclic group, an aromatic group, urethane, urea, an ester group, an NR_5 group, a CHR_6 group, or a CR_7R_8 group where R_5 , R_6 , R_7 , and R_8 comprise, each independently, H, hydroxyl group, thiol group, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

T_1 and T_2 are, each independently, a thiiranyl group, H, an alkyl group, an alkenyl group, or an aromatic group with the proviso that at least one of T_1 and T_2 is a thiiranyl group; and

[0038] Ar comprises an aromatic group with the proviso that when both Y_1 and Y_2 are a bond and one of T_1 and T_2 is not a thiiranyl group, Ar comprises a bis[(N,N-disubstituted)amino] aromatic group or a bicarbazole group.

[0039] In sixth aspect of the present invention there is provided an organophotoreceptor comprising an electrically conductive substrate and a photoconductive element on the electrically conductive substrate, the photoconductive element comprising:

- (a) the polymeric charge transport compound described above; and
- (b) a charge generating compound.

[0040] The invention provides suitable charge transport materials for organophotoreceptors featuring a combination of good mechanical and electrostatic properties. These photoreceptors can be used successfully with liquid toners to produce high quality images. The high quality of the imaging system can be maintained after repeated cycling. The invention provides organophotoreceptors having good electrostatic properties such as high V_{acc} and low V_{dis} . The invention also provides charge transport materials having a high compatibility with the polymeric binder, minimal phase separation, and minimal extraction by liquid carriers.

[0041] Other features and advantages of the invention will be apparent from the following description of the particular embodiments thereof, and from the claims.

[0042] Features and embodiments described herein of the first, second, third, fourth, fifth and sixth aspects of the present invention, respectively, may be regarded as preferred features and embodiments of other aspects of the present invention.

[0043] An organophotoreceptor as described herein has an electrically conductive substrate and a photoconductive element comprising a charge generating compound and a charge transport material having at least a thiiranyl group attached through a linking group to either a hydrazone, a diazine, or an aromatic group. These charge transport materials have desirable properties as evidenced by their performance in organophotoreceptors for electrophotography. In particular, the charge transport materials of this invention have high charge carrier mobilities and good compatibility with various binder materials, and possess excellent electrophotographic properties. The organophotoreceptors according to this invention generally have a high photosensitivity, a low residual potential, and a high stability with respect to cycle testing, crystallization, and organophotoreceptor bending and stretching. The organophotoreceptors are particularly useful in laser printers and the like as well as fax machines, photocopiers, scanners and other electronic devices based on electrophotography. The use of these charge transport materials is described in more detail below in the context of laser printer use, although their application in other devices operating by electrophotography can be generalized from the discussion below.

[0044] As noted above, to produce high quality images, particularly after multiple cycles, it is desirable for the charge transport materials to form a homogeneous solution with the polymeric binder and remain approximately homogeneously distributed through the organophotoreceptor material during the cycling of the material. In addition, it is desirable to increase the amount of charge that the charge transport material can accept (indicated by a parameter known as the acceptance voltage or " V_{acc} "), and to reduce retention of that charge upon discharge (indicated by a parameter known as the discharge voltage or " V_{dis} ").

[0045] The charge transport materials can be classified as a charge transport compound or an electron transport compound. There are many charge transport compounds and electron transport compounds known in the art for electrophotography. Non-limiting examples of charge transport compounds include, for example, pyrazoline derivatives, fluorene derivatives, oxadiazole derivatives, stilbene derivatives, enamine derivatives, enamine stilbene derivatives, hydrazone derivatives, carbazole hydrazone derivatives, (N,N-disubstituted)arylamines such as triaryl amines, polyvinyl carbazole, polyvinyl pyrene, polyacacenaphthylene, or multi-hydrazone compounds comprising at least two hydra-

zone groups and at least two groups selected from the group consisting of (N,N-disubstituted)arylamine such as triphenylamine and heterocycles such as carbazole, julolidine, phenothiazine, phenazine, phenoxazine, phenoxathiin, thiazole, oxazole, isoxazole, dibenzo(1,4)dioxin, thianthrene, imidazole, benzothiazole, benzotriazole, benzoxazole, benzimidazole, quinoline, isoquinoline, quinoxaline, indole, indazole, pyrrole, purine, pyridine, pyridazine, pyrimidine, pyrazine, triazole, oxadiazole, tetrazole, thiadiazole, benzisoxazole, benzisothiazole, dibenzofuran, dibenzothiophene, thiophene, thianaphthene, quinazoline, or cinnoline.

[0046] Non-limiting examples of electron transport compounds include, for example, bromoaniline, tetracyanoethylene, tetracyanoquinodimethane, 2,4,7-trinitro-9-fluorenone, 2,4,5,7-tetranitro-9-fluorenone, 2,4,5,7-tetranitroxanthone, 2,4,8-trinitrothioxanthone, 2,6,8-trinitro-indeno[1,2-b]thiophene-4-one, and 1,3,7-trinitrodibenzo thiophene-5,5-dioxide, (2,3-diphenyl-1-indenylidene)malononitrile, 4H-thiopyran-1,1-dioxide and its derivatives such as 4-dicyanomethylene-2,6-diphenyl-4H-thiopyran-1,1-dioxide, 4-dicyanomethylene-2,6-di-m-tolyl-4H-thiopyran-1,1-dioxide, and unsymmetrically substituted 2,6-diaryl-4H-thiopyran-1,1-dioxide such as 4H-1,1-dioxo-2-(p-isopropylphenyl)-6-phenyl-4-(dicyanomethylidene)thiopyran and 4H-1,1-dioxo-2-(p-isopropylphenyl)-6-(2-thienyl)-4-(dicyanomethylidene)thiopyran, derivatives of phospho-2,5-cyclohexadiene, alkoxycarbonyl-9-fluorenylidene)malononitrile derivatives such as (4-n-butoxycarbonyl-9-fluorenylidene)malononitrile, (4-phenethoxycarbonyl-9-fluorenylidene)malononitrile, (4-carbitoxyl-9-fluorenylidene)malononitrile, and diethyl(4-n-butoxycarbonyl-2,7-dinitro-9-fluorenylidene)-malonate, anthraquinodimethane derivatives such as 11, 11, 12,12-tetracyano-2-alkylanthraquinodimethane and 11,11-dicyano-12,12-bis(ethoxycarbonyl)anthraquinodimethane, anthrone derivatives such as 1-chloro-10-[bis(ethoxycarbonyl)methylene]anthrone, 1,8-dichloro-10-[bis(ethoxy carbonyl) methylene]anthrone, 1,8-dihydroxy-10-[bis(ethoxycarbonyl)methylene]anthrone, and 1-cyano-10-[bis(ethoxycarbonyl)methylene]anthrone, 7-nitro-2-aza-9-fluorenylidene-malononitrile, diphenoquinone derivatives, benzoquinone derivatives, naphthoquinone derivatives, quinine derivatives, tetracyanoethylenecyanoethylene, 2,4,8-trinitro thioxanthone, dinitrobenzene derivatives, dinitroanthracene derivatives, dinitroacridine derivatives, nitroanthraquinone derivatives, dinitroanthraquinone derivatives, succinic anhydride, maleic anhydride, dibromo maleic anhydride, pyrene derivatives, carbazole derivatives, hydrazone derivatives, N,N-dialkylaniline derivatives, diphenylamine derivatives, triphenylamine derivatives, triphenylmethane derivatives, tetracyano quinoedimethane, 2,4,5,7-tetranitro-9-fluorenone, 2,4,7-trinitro-9-dicyanomethylene fluorenone, 2,4,5,7-tetranitroxanthone derivatives, and 2,4,8-trinitrothioxanthone derivatives. In some embodiments of interest, the electron transport compound comprises an (alkoxycarbonyl-9-fluorenylidene)malononitrile derivative, such as (4-n-butoxycarbonyl-9-fluorenylidene)malononitrile.

[0047] Although there are many charge transport materials available, as noted above, there is a need for other charge transport materials to meet the various requirements of particular electrophotography applications.

[0048] In electrophotography applications, a charge-generating compound within an organophotoreceptor absorbs light to form electron-hole pairs. These electrons and holes can be transported over an appropriate time frame under a large electric field to discharge locally a surface charge that is generating the field. The discharge of the field at a particular location results in a surface charge pattern that essentially matches the pattern drawn with the light. This charge pattern then can be used to guide toner deposition. The charge transport materials described herein are especially effective at transporting charge, and in particular holes from the electron-hole pairs formed by the charge generating compound. In some embodiments, a specific electron transport compound or charge transport compound can also be used along with the charge transport material of this invention.

[0049] The layer or layers of materials containing the charge generating compound and the charge transport materials are within an organophotoreceptor. To print a two dimensional image using the organophotoreceptor, the organophotoreceptor has a two dimensional surface for forming at least a portion of the image. The imaging process then continues by cycling the organophotoreceptor to complete the formation of the entire image and/or for the processing of subsequent images.

[0050] The organophotoreceptor may be provided in the form of a plate, a flexible belt, a disk, a rigid drum, a sheet around a rigid or compliant drum, or the like. The charge transport material can be in the same layer as the charge generating compound and/or in a different layer from the charge generating compound. Additional layers can be used also, as described further below.

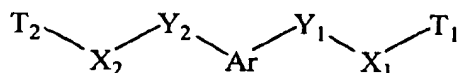
[0051] In some embodiments, the organophotoreceptor material comprises, for example: (a) a charge transport layer comprising the charge transport material and a polymeric binder; (b) a charge generating layer comprising the charge generating compound and a polymeric binder; and (c) the electrically conductive substrate. The charge transport layer may be intermediate between the charge generating layer and the electrically conductive substrate. Alternatively, the charge generating layer may be intermediate between the charge transport layer and the electrically conductive substrate. In further embodiments, the organophotoreceptor material has a single layer with both a charge transport material and a charge generating compound within a polymeric binder.

[0052] The organophotoreceptors can be incorporated into an electrophotographic imaging apparatus, such as laser printers. In these devices, an image is formed from physical embodiments and converted to a light image that is scanned onto the organophotoreceptor to form a surface latent image. The surface latent image can be used to attract toner

onto the surface of the organophotoreceptor, in which the toner image is the same or the negative of the light image projected onto the organophotoreceptor. The toner can be a liquid toner or a dry toner. The toner is subsequently transferred, from the surface of the organophotoreceptor, to a receiving surface, such as a sheet of paper. After the transfer of the toner, the entire surface is discharged, and the material is ready to cycle again. The imaging apparatus can further comprise, for example, a plurality of support rollers for transporting a paper receiving medium and/or for movement of the photoreceptor, a light imaging component with suitable optics to form the light image, a light source, such as a laser, a toner source and delivery system and an appropriate control system.

[0053] An electrophotographic imaging process generally can comprise (a) applying an electrical charge to a surface of the organophotoreceptor described herein; (b) imagewise exposing the surface of the organophotoreceptor to radiation to dissipate charge in selected areas and thereby form a pattern of charged and uncharged areas on the surface; (c) exposing the surface with a toner, such as a liquid toner that includes a dispersion of colorant particles in an organic liquid to create a toner image, to attract toner to the charged or discharged regions of the organophotoreceptor; and (d) transferring the toner image to a substrate.

[0054] As described herein, in an aspect of the present invention, for example in the first aspect herein, an organophotoreceptor comprises a charge transport material having the formula



where Y_1 and Y_2 are, each independently, a bond, $-CR_1=N-NR_2-$, or $-CR_3=N-N=CR_4-$ where R_1 , R_2 , R_3 , and R_4 comprise, each independently, H, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

X_1 and X_2 are, each independently, a linking group having the formula $-(CH_2)_m-$, branched or linear, where m is an integer between 0 and 20, inclusive, and one or more of the methylene groups is optionally replaced by O, S, C=O, O=S=O, a heterocyclic group, an aromatic group, urethane, urea, an ester group, an NR_5 group, a CHR_6 group, or a CR_7R_8 group where R_5 , R_6 , R_7 , and R_8 comprise, each independently, H, hydroxyl group, thiol group, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

T_1 and T_2 are, each independently, a thiiranyl group, H, an alkyl group, an alkenyl group, or an aromatic group with the proviso that at least one of T_1 and T_2 is a thiiranyl group; and

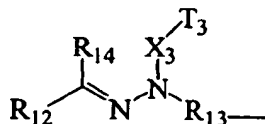
Ar comprises an aromatic group with the proviso that when both Y_1 and Y_2 are a bond and one of T_1 and T_2 is not a thiiranyl group, Ar comprises a bis[(N,N-disubstituted)amino]aromatic group or a bicarbazoyl group.

[0055] Preferably, T_2 is H, the m value for X_2 is 0, Y_2 is a bond, Y_1 is $-CR_1=N-NR_2-$ where the C atom is connected to Ar and the terminal N atom is connected to X_1 , and T_1 comprises a thiiranyl group.

[0056] Preferably, Ar comprises an arylamine group or an aromatic heterocyclic group.

[0057] Preferably, R_2 comprises an aromatic group.

[0058] Preferably, the aromatic group of R_2 has the formula



where R_{12} comprises an arylamine group, R_{13} is a linking group comprising an alkyl group, an alkenyl group, or an aryl group, R_{14} comprises H, an alkyl group, an alkenyl group, or an aryl group, X_3 has the formula $-(CH_2)_m-$, branched or linear, where m is an integer between 1 and 20, and T_3 is a thiiranyl group.

[0059] Preferably, the m value for X_1 is 0, T_1 comprises an aromatic group, T_2 comprises a thiiranyl group, Y_2 is a bond, and Y_1 is $-CR_1=N-NR_2-$ where the C atom is connected to Ar and the terminal N atom is connected directly to T_1 .

[0060] Preferably, T_2 is H, the m value for X_2 is 0, Y_2 is a bond, Y_1 is $-CR_3=N-N=CR_4-$, and T_1 comprises a thiiranyl group.

[0061] Preferably, Y_1 and Y_2 are a bond and Ar comprises a bis[(N,N-disubstituted)amino]arylene group.

[0062] Preferably, T_2 is H, an alkyl group, an alkenyl group, or an aromatic group.

[0063] Preferably, Y_1 and Y_2 are a bond, Ar comprises two arylamine groups.

[0064] Preferably, Ar is a bicarbazole group.

[0065] Preferably, Ar comprises an arylamine group, Y_1 and Y_2 are each independently $-CR_1=N-NR_2-$, and T_1 and T_2 , each independently, comprise a thiiranyl group.

[0066] Preferably, the photoconductive element of the organophotoreceptor further comprises a second charge transport material.

[0067] Preferably, the second charge transport material comprises an electron transport compound.

[0068] Preferably, the photoconductive element of the organophotoreceptor further comprises a binder.

[0069] In some embodiments, X_1 and X_2 are, each independently, a linking group having the formula $-(CH_2)_m-$, branched or linear, where m is an integer between 0 and 12, inclusive, especially between 0 and 6, inclusive, and one or more of the methylene groups is optionally replaced by O, S, C=O, O=S=O, a heterocyclic group, an aromatic group, urethane, urea, an ester group, an NR_5 group, a CHR_6 group, or a CR_7R_8 group where R_5 , R_6 , R_7 , and R_8 comprise, each independently, H, hydroxyl group, thiol group, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

[0070] An aromatic group can be any conjugated system containing $4n + 2$ π -electrons. There are many criteria available for determining aromaticity. A widely employed criterion for the quantitative assessment of aromaticity is the resonance energy. In general, the resonance energy of the aromatic group is greater than 10 KJ/mol. Aromatic groups may be classified as an aromatic heterocyclic group which contains at least a heteroatom in the $4n + 2$ π -electron ring, or as an aryl group which does not contain a heteroatom in the $4n + 2$ π -electron ring. Nonetheless, either the aromatic heterocyclic or the aryl group may have at least one heteroatom in a substituent attached to the $4n + 2$ π -electron ring. Furthermore, either the aromatic heterocyclic or the aryl group may comprise a monocyclic or polycyclic (such as bicyclic, tricyclic, etc.) aromatic ring.

[0071] Non-limiting examples of the aromatic heterocyclic group are furanyl, thiophenyl, pyrrolyl, indolyl, carbazoyl, benzofuranyl, benzothiophenyl, dibenzofuranyl, dibenzothiophenyl, pyridinyl, pyridazinyl, pyrimidinyl, pyrazinyl, triazinyl, tetrazinyl, petazinyl, quinolinyl, isoquinolinyl, cinnolinyl, phthalazinyl, quinazolinyl, quinoxalinyl, naphthyridinyl, pteridinyl, acridinyl, phenanthridinyl, phenanthrolinyl, anthyridinyl, purinyl, pteridinyl, alloxazinyl, phenazinyl, phenothiazinyl, phenoxazinyl, phenoxathiinyl, dibenzo(1,4)dioxinyl, thianthrenyl, and a combination thereof. The aromatic heterocyclic group may also include any combination of the above aromatic heterocyclic groups bonded together either by a bond (as in bicarbazoyl) or by a linking group (as in 1,6 di(10H-10-phenothiazinyl)hexane). The linking group may include an aliphatic group, an aromatic group, a heterocyclic group, or a combination thereof. Furthermore, either an aliphatic group or an aromatic group within a linking group may comprise at least one heteroatom such as O, S, and N. Non-limiting examples of the aryl group are phenyl, naphthyl, benzyl, or tolyl group, sexiphenylene, phenanthrenyl, anthracenyl, coronenyl, and tolylphenyl. The aryl group may also include any combination of the above aryl groups bonded together either by a bond (as in biphenyl group) or a linking group (as in stilbenyl, diphenyl sulfone, an arylamine group). The linking group may include an aliphatic group, an aromatic group, a heterocyclic group, or a combination thereof. Furthermore, either an aliphatic group or an aromatic group within a linking group may comprise at least one heteroatom such as O, S, and N.

[0072] An arylamine group includes p -(N,N-disubstituted)arylamine group (e.g., triphenylamine, diethylphenylamine, and ethyldiphenylamine group), carbazoyl group, and julolidinyl group. A bis[(N,N-disubstituted)amino]aromatic group contains a monocyclic, bicyclic, or polycyclic aromatic ring and two (N,N-disubstituted)amino groups directly linked to the monocyclic or polycyclic (such as bicyclic, tricyclic, etc.) aromatic ring. Non-limiting examples of the bis[(N,N-disubstituted)amino]aromatic group are 1,3-bis(4,4'-dimethyl-diphenylamino)phenyl and 1,3-bis(diphenylamino)phenyl.

[0073] Substitution is liberally allowed on the chemical groups to affect various physical effects on the properties of the compounds, such as mobility, sensitivity, solubility, stability, and the like, as is known generally in the art. In the description of chemical substituents, there are certain practices common to the art that are reflected in the use of language. The term group indicates that the generically recited chemical entity (e.g., alkyl group, alkenyl group, aromatic group, thiranyl group, etc.) may have any substituent thereon which is consistent with the bond structure of that group. For example, where the term 'alkyl group' is used, that term would not only include unsubstituted linear, branched and cyclic alkyls, such as methyl, ethyl, isopropyl, tert-butyl, cyclohexyl, dodecyl and the like, but also substituents having heteroatom such as 3-ethoxypropyl, 4-(N-ethylamino)butyl, 3-hydroxypentyl, 2-thiolhexyl, 1,2,3-tribromopropyl, and the like. However, as is consistent with such nomenclature, no substitution would be included within the term that would alter the fundamental bond structure of the underlying group. For example, where a phenyl group is recited, substitution such as 1-aminophenyl, 2,4-dihydroxyphenyl, 1,3,5-trithiophenyl, 1,3,5-trimethoxyphenyl and the like would be acceptable within the terminology, while substitution of 1,1,2,2,3,3-hexamethylphenyl would not be acceptable as that substitution would require the ring bond structure of the phenyl group to be altered to a non-aromatic form because of the substitution. When referring to a thiranyl group, the substituent cited will include any substitution that does not destroy the 3-membered ring structure of the thiranyl group. Where the term moiety is used, such as alkyl moiety or phenyl moiety, that terminology indicates that the chemical moiety is not substituted. When referring to an alkyl moiety, the term represents only an unsubstituted alkyl hydrocarbon group, whether branched, straight chain, or cyclic.

[0074] In general, and except where stated otherwise herein, the following apply. Preferred alkyl groups are C_{1-18} alkyl, especially C_{1-12} alkyl, more especially C_{1-8} alkyl, even more especially C_{1-4} alkyl, suitably substituted or unsubstituted, suitably linear, branched or cyclic.

Organophotoreceptors

[0075] The organophotoreceptor may be, for example, in the form of a plate, a sheet, a flexible belt, a disk, a rigid drum, or a sheet around a rigid or compliant drum, with flexible belts and rigid drums generally being used in commercial embodiments. The organophotoreceptor may comprise, for example, an electrically conductive substrate and on the electrically conductive substrate a photoconductive element in the form of one or more layers. The photoconductive element can comprise both a charge transport material and a charge generating compound in a polymeric binder, which may or may not be in the same layer, as well as a second charge transport material such as a charge transport compound or an electron transport compound in some embodiments. For example, the charge transport material and the charge generating compound can be in a single layer. In other embodiments, however, the photoconductive element comprises a bilayer construction featuring a charge generating layer and a separate charge transport layer. The charge generating layer may be located intermediate between the electrically conductive substrate and the charge transport layer. Alternatively, the photoconductive element may have a structure in which the charge transport layer is intermediate between the electrically conductive substrate and the charge generating layer.

[0076] The electrically conductive substrate may be flexible, for example in the form of a flexible web or a belt, or inflexible, for example in the form of a drum. A drum can have a hollow cylindrical structure that provides for attachment of the drum to a drive that rotates the drum during the imaging process. Typically, a flexible electrically conductive substrate comprises an electrically insulating substrate and a thin layer of electrically conductive material onto which the photoconductive material is applied.

[0077] The electrically insulating substrate may be paper or a film forming polymer such as polyester (e.g., polyethylene terephthalate or polyethylene naphthalate), polyimide, polysulfone, polypropylene, nylon, polyester, polycarbonate, polyvinyl resin, polyvinyl fluoride, polystyrene and the like. Specific examples of polymers for supporting substrates included, for example, polyethersulfone (Stabar™ S-100, available from ICI), polyvinyl fluoride (Tedlar®, available from E.I. DuPont de Nemours & Company), polybisphenol-A polycarbonate (Makrofol™, available from Mobay Chemical Company) and amorphous polyethylene terephthalate (Melinar™, available from ICI Americas, Inc.). The electrically conductive materials may be graphite, dispersed carbon black, iodine, conductive polymers such as polypyrroles and Calgon® conductive polymer 261 (commercially available from Calgon Corporation, Inc., Pittsburgh, Pa.), metals such as aluminum, titanium, chromium, brass, gold, copper, palladium, nickel, or stainless steel, or metal oxide such as tin oxide or indium oxide. In embodiments of particular interest, the electrically conductive material is aluminum. Generally, the photoconductor substrate has a thickness adequate to provide the required mechanical stability. For example, flexible web substrates generally have a thickness from about 0.01 to about 1 mm, while drum substrates generally have a thickness from about 0.5 mm to about 2 mm.

[0078] The charge generating compound is a material that is capable of absorbing light to generate charge carriers, such as a dye or pigment. Non-limiting examples of suitable charge generating compounds include, for example, metal-free phthalocyanines (e.g., ELA 8034 metal-free phthalocyanine available from H.W. Sands, Inc. or Sanyo Color Works, Ltd., CGM-X01), metal phthalocyanines such as titanium phthalocyanine, copper phthalocyanine, oxytitanium phthalocyanine (also referred to as titanyl oxyphthalocyanine, and including any crystalline phase or mixtures of crystalline phases that can act as a charge generating compound), hydroxygallium phthalocyanine, squarylium dyes and pigments, hydroxy-substituted squarylium pigments, perylimides, polynuclear quinones available from Allied Chemical Corporation under the trade name Indofast® Double Scarlet, Indofast® Violet Lake B, Indofast® Brilliant Scarlet and Indofast® Orange, quinacridones available from DuPont under the trade name Monastral™ Red, Monastral™ Violet and Monastral™ Red Y, naphthalene 1,4,5,8-tetracarboxylic acid derived pigments including the perinones, tetrabenzoporphyrins and tetranaphthaloporphyrins, indigo- and thioindigo dyes, benzothioxanthene-derivatives, perylene 3,4,9,10-tetracarboxylic acid derived pigments, polyazo-pigments including bisazo-, trisazo- and tetrakisazo-pigments, polymethine dyes, dyes containing quinazoline groups, tertiary amines, amorphous selenium, selenium alloys such as selenium-tellurium, selenium-tellurium-arsenic and selenium-arsenic, cadmium sulphoselenide, cadmium selenide, cadmium sulphide, and mixtures thereof. For some embodiments, the charge generating compound comprises oxytitanium phthalocyanine (e.g., any phase thereof), hydroxygallium phthalocyanine or a combination thereof.

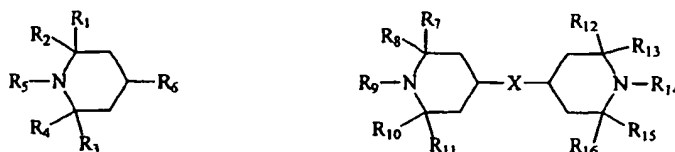
[0079] The photoconductive layer of this invention may optionally contain a second charge transport material which may be a charge transport compound, an electron transport compound, or a combination of both. Generally, any charge transport compound or electron transport compound known in the art can be used as the second charge transport material.

[0080] An electron transport compound and a UV light stabilizer can have a synergistic relationship for providing desired electron flow within the photoconductor. The presence of the UV light stabilizers alters the electron transport properties of the electron transport compounds to improve the electron transporting properties of the composite. UV light stabilizers can be ultraviolet light absorbers or ultraviolet light inhibitors that trap free radicals.

[0081] UV light absorbers can absorb ultraviolet radiation and dissipate it as heat. UV light inhibitors are thought to trap free radicals generated by the ultraviolet light and after trapping of the free radicals, subsequently to regenerate

active stabilizer moieties with energy dissipation. In view of the synergistic relationship of the UV stabilizers with electron transport compounds, the particular advantages of the UV stabilizers may not be their UV stabilizing abilities, although the UV stabilizing ability may be further advantageous in reducing degradation of the organophotoreceptor over time. The improved synergistic performance of organophotoreceptors with layers comprising both an electron transport compound and a UV stabilizer are described further in copending U.S. Patent Application Serial Number 10/425,333 filed on April 28, 2003 to Zhu, entitled "Organophotoreceptor With A Light Stabilizer", published as US 2003/0228534 A1, incorporated herein by reference.

[0082] Non-limiting examples of suitable light stabilizer include, for example, hindered trialkylamines such as Tinuvin 144 and Tinuvin 292 (from Ciba Specialty Chemicals, Terrytown, NY), hindered alkoxydialkylamines such as Tinuvin 123 (from Ciba Specialty Chemicals), benzotriazoles such as Tinuvan 328, Tinuvin 900 and Tinuvin 928 (from Ciba Specialty Chemicals), benzophenones such as Sanduvor 3041 (from Clariant Corp., Charlotte, N.C.), nickel compounds such as Arbostab (from Robinson Brothers Ltd, West Midlands, Great Britain), salicylates, cyanocinnamates, benzylidene malonates, benzoates, oxanilides such as Sanduvor VSU (from Clariant Corp., Charlotte, N.C.), triazines such as Cyagard UV-1164 (from Cytec Industries Inc., N.J.), polymeric sterically hindered amines such as Luchem (from Atochem North America, Buffalo, NY). In some embodiments, the light stabilizer is selected from the group consisting of hindered trialkylamines having the following formula:



where $R_1, R_2, R_3, R_4, R_6, R_7, R_8, R_{10}, R_{11}, R_{12}, R_{13}, R_{15}$ and R_{16} are, each independently, hydrogen, alkyl group, or ester, or ether group; and R_5, R_9 , and R_{14} are, each independently, alkyl group; and X is a linking group selected from the group consisting of $-O-CO-(CH_2)_m-CO-O-$ where m is between 2 to 20.

[0083] Optionally, the photoconductive layer may comprise a crosslinking agent linking the charge transport compound and the binder. As is generally true for crosslinking agents in various contexts, the crosslinking agent comprises a plurality of functional groups or at least one functional group with the ability to exhibit multiple functionality. Specifically, a suitable crosslinking agent generally comprises at least one functional group that reacts with a thiiranyl group and at least one functional group reactive with a functional group of the polymeric binder. Suitable functional groups for reacting with the thiiranyl group include, for example, a reactive functionality, such as hydroxyl, thiol, an amino group, a carboxyl group, or a combination thereof. In some embodiments, the functional group for reacting with the polymeric binder does not react significantly with the thiiranyl group. In general, a person of ordinary skill in the art can select the appropriate functional group of the crosslinking agent to react with the polymeric binder, or similarly, a person of ordinary skill in the art can select appropriate functional groups of the polymeric binder to react with the functional group of the crosslinking agent. Suitable functional groups of the crosslinking agent that do not react significantly with the thiiranyl group, at least under selected conditions, include, for example, thiiranyl groups, aldehydes and ketones. Suitable reactive binder functional groups for reacting with the aldehydes and ketones include, for example, amines.

[0084] In some embodiments, the crosslinking agent is a cyclic acid anhydride, which effectively is at least bifunctional. Non-limiting examples of suitable cyclic acid anhydrides include, for example, 1,8-naphthalene dicarboxylic acid anhydride, itaconic anhydride, glutaric anhydride and citraconic anhydride, fumaric anhydride, phthalic anhydride, isophthalic anhydride, and terephthalic anhydride with maleic anhydride and phthalic anhydride being of particular interest.

[0085] The binder generally is capable of dispersing or dissolving the charge transport compound (in the case of the charge transport layer or a single layer construction) and/or the charge generating compound (in the case of the charge generating layer or a single layer construction). Examples of suitable binders for both the charge generating layer and charge transport layer generally include, for example, polystyrene-co-butadiene, polystyrene-co-acrylonitrile, modified acrylic polymers, polyvinyl acetate, styrene-alkyd resins, soya-alkyl resins, polyvinylchloride, polyvinylidene chloride, polyacrylonitrile, polycarbonates, polyacrylic acid, polyacrylates, polymethacrylates, styrene polymers, polyvinyl butyral, alkyd resins, polyamides, polyurethanes, polyesters, polysulfones, polyethers, polyketones, phenoxy resins, epoxy resins, silicone resins, polysiloxanes, poly(hydroxyether) resins, polyhydroxystyrene resins, novolak, poly(phenylglycidyl ether)-co-dicyclopentadiene, copolymers of monomers used in the above-mentioned polymers, and combinations thereof. In some embodiments, the binder comprises a polymer with a reactive hydrogen functionality, such as hydroxyl, thiol, an amino group, a carboxyl group, or a combination thereof, that can react with the thiiranyl ring of the charge transport compounds of this invention or with a functional group of a crosslinking agent, such as a cyclic acid anhydride. In the organophotoreceptor, the functional group of the polymer can be bonded directly with the thiiranyl group or indirectly through a co-reactive crosslinking agent, for example, a cyclic acid anhydride group, to form the

corresponding and predictable reaction product. Suitable binders with reactive functionality include, for example, polyvinyl butyral, such as BX-1 and BX-5 from Sekisui Chemical Co. Ltd., Japan.

[0086] Suitable optional additives for any one or more of the layers include, for example, antioxidants, coupling agents, dispersing agents, curing agents, surfactants, and combinations thereof.

5 **[0087]** The photoconductive element overall typically has a thickness from about 10 microns to about 45 microns. In the dual layer embodiments having a separate charge generating layer and a separate charge transport layer, charge generation layer generally has a thickness from about 0.5 microns to about 2 microns, and the charge transport layer has a thickness from about 5 microns to about 35 microns. In embodiments in which the charge transport material and the charge generating compound are in the same layer, the layer with the charge generating compound and the charge transport composition generally has a thickness from about 7 microns to about 30 microns. In embodiments with a distinct electron transport layer, the electron transport layer has an average thickness from about 0.5 microns to about 10 microns and in further embodiments from about 1 micron to about 3 microns. In general, an electron transport overcoat layer can increase mechanical abrasion resistance, increases resistance to carrier liquid and atmospheric moisture, and decreases degradation of the photoreceptor by corona gases. A person of ordinary skill in the art will recognize that additional ranges of thickness within the explicit ranges above are contemplated and are within the present disclosure.

15 **[0088]** Generally, for the organophotoreceptors described herein, the charge generation compound is in an amount from about 0.5 to about 25 weight percent, in further embodiments in an amount from about 1 to about 15 weight percent, and in other embodiments in an amount from about 2 to about 10 weight percent, based on the weight of the photoconductive layer. Suitably, the charge transport material is in an amount from about 10 to about 80 weight percent, based on the weight of the photoconductive layer, in further embodiments in an amount from about 35 to about 60 weight percent, and in other embodiments from about 45 to about 55 weight percent, based on the weight of the photoconductive layer. The optional second charge transport material, when present, can be in an amount of at least about 2 weight percent, in other embodiments from about 2.5 to about 25 weight percent, based on the weight of the photoconductive layer, and in further embodiments in an amount from about 4 to about 20 weight percent, based on the weight of the photoconductive layer. Suitably, the binder is in an amount from about 15 to about 80 weight percent, based on the weight of the photoconductive layer, and in further embodiments in an amount from about 20 to about 75 weight percent, based on the weight of the photoconductive layer. A person of ordinary skill in the art will recognize that additional ranges within the explicit ranges of compositions are contemplated and are within the present disclosure.

30 **[0089]** For the dual layer embodiments with a separate charge generating layer and a charge transport layer, the charge generation layer generally comprises a binder in an amount from about 10 to about 90 weight percent, in further embodiments from about 15 to about 80 weight percent and in some embodiments in an amount from about 20 to about 75 weight percent, based on the weight of the charge generation layer. The optional charge transport material in the charge generating layer, if present, generally can be in an amount of at least about 2.5 weight percent, in further embodiments from about 4 to about 30 weight percent and in other embodiments in an amount from about 10 to about 25 weight percent, based on the weight of the charge generating layer. The charge transport layer generally comprises a binder in an amount from about 20 weight percent to about 70 weight percent and in further embodiments in an amount from about 30 weight percent to about 50 weight percent. A person of ordinary skill in the art will recognize that additional ranges of binder concentrations for the dual layer embodiments within the explicit ranges above are contemplated and are within the present disclosure.

40 **[0090]** For the embodiments with a single layer having a charge generating compound and a charge transport material, the photoconductive layer generally comprises a binder, a charge transport material, and a charge generation compound. The charge generation compound can be in an amount from about 0.05 to about 25 weight percent and in further embodiment in an amount from about 2 to about 15 weight percent, based on the weight of the photoconductive layer. The charge transport material can be in an amount from about 10 to about 80 weight percent, in other embodiments from about 25 to about 65 weight percent, in additional embodiments from about 30 to about 60 weight percent and in further embodiments in an amount from about 35 to about 55 weight percent, based on the weight of the photoconductive layer, with the remainder of the photoconductive layer comprising the binder, and optional additives, such as any conventional additives. A single layer with a charge transport composition and a charge generating compound generally comprises a binder in an amount from about 10 weight percent to about 75 weight percent, in other embodiments from about 20 weight percent to about 60 weight percent, and in further embodiments from about 25 weight percent to about 50 weight percent. Optionally, the layer with the charge generating compound and the charge transport material may comprise a second charge transport material. The optional second charge transport material, if present, generally can be in an amount of at least about 2.5 weight percent, in further embodiments from about 4 to about 30 weight percent and in other embodiments in an amount from about 10 to about 25 weight percent, based on the weight of the photoconductive layer. A person of ordinary skill in the art will recognize that additional composition ranges within the explicit compositions ranges for the layers above are contemplated and are within the present disclosure.

55 **[0091]** In general, any layer with an electron transport compound can advantageously further include a UV light

stabilizer. In particular, the electron transport layer generally can comprise an electron transport compound, a binder, and an optional UV light stabilizer. An overcoat layer comprising an electron transport compound is described further in copending U.S. Patent Application Serial No. 10/396,536 to Zhu et al. entitled, "Organophotoreceptor With An Electron Transport Layer," published as US 2003/0194626 A1, incorporated herein by reference. For example, an electron transport compound as described above may be used in the release layer of the photoconductors described herein. The electron transport compound in an electron transport layer can be in an amount from about 10 to about 50 weight percent, and in other embodiments in an amount from about 20 to about 40 weight percent, based on the weight of the electron transport layer. A person of ordinary skill in the art will recognize that additional ranges of compositions within the explicit ranges are contemplated and are within the present disclosure.

[0092] The UV light stabilizer, if present, in any one or more appropriate layers of the photoconductor generally is in an amount from about 0.5 to about 25 weight percent and in some embodiments in an amount from about 1 to about 10 weight percent, based on the weight of the particular layer. A person of ordinary skill in the art will recognize that additional ranges of compositions within the explicit ranges are contemplated and are within the present disclosure.

[0093] For example, the photoconductive layer may be formed by dispersing or dissolving the components, such as one or more of a charge generating compound, the charge transport material of this invention, a second charge transport material such as a charge transport compound or an electron transport compound, a UV light stabilizer, and a polymeric binder in organic solvent, coating the dispersion and/or solution on the respective underlying layer and drying the coating. In particular, the components can be dispersed by high shear homogenization, ball-milling, attritor milling, high energy bead (sand) milling or other size reduction processes or mixing means known in the art for effecting particle size reduction in forming a dispersion.

[0094] The photoreceptor may optionally have one or more additional layers as well. An additional layer can be, for example, a sub-layer or an overcoat layer, such as a barrier layer, a release layer, a protective layer, or an adhesive layer. A release layer or a protective layer may form the uppermost layer of the photoconductor element. A barrier layer may be sandwiched between the release layer and the photoconductive element or used to overcoat the photoconductive element. The barrier layer provides protection from abrasion to the underlayers. An adhesive layer locates and improves the adhesion between a photoconductive element, a barrier layer, and a release layer, or any combination thereof. A sub-layer is a charge blocking layer and locates between the electrically conductive substrate and the photoconductive element. The sub-layer may also improve the adhesion between the electrically conductive substrate and the photoconductive element.

[0095] Suitable barrier layers include, for example, coatings such as crosslinkable siloxanol-colloidal silica coating and hydroxylated silsesquioxane-colloidal silica coating, and organic binders such as polyvinyl alcohol, methyl vinyl ether/maleic anhydride copolymer, casein, polyvinyl pyrrolidone, polyacrylic acid, gelatin, starch, polyurethanes, polyimides, polyesters, polyamides, polyvinyl acetate, polyvinyl chloride, polyvinylidene chloride, polycarbonates, polyvinyl butyral, polyvinyl acetoacetal, polyvinyl formal, polyacrylonitrile, polymethyl methacrylate, polyacrylates, polyvinyl carbazoles, copolymers of monomers used in the above-mentioned polymers, vinyl chloride/vinyl acetate/vinyl alcohol terpolymers, vinyl chloride/vinyl acetate/maleic acid terpolymers, ethylene/vinyl acetate copolymers, vinyl chloride/vinylidene chloride copolymers, cellulose polymers, and mixtures thereof. The above barrier layer polymers optionally may contain small inorganic particles such as fumed silica, silica, titania, alumina, zirconia, or a combination thereof. Barrier layers are described further in U.S. Patent 6,001,522 to Woo et al., entitled "Barrier Layer For Photoconductor Elements Comprising An Organic Polymer And Silica," incorporated herein by reference. The release layer topcoat may comprise any release layer composition known in the art. In some embodiments, the release layer is a fluorinated polymer, siloxane polymer, fluorosilicone polymer, silane, polyethylene, polypropylene, polyacrylate, or a combination thereof. The release layers can comprise crosslinked polymers.

[0096] The release layer may comprise, for example, any release layer composition known in the art. In some embodiments, the release layer comprises a fluorinated polymer, siloxane polymer, fluorosilicone polymer, polysilane, polyethylene, polypropylene, polyacrylate, poly(methyl methacrylate-co-methacrylic acid), urethane resins, urethane-epoxy resins, acrylated-urethane resins, urethane-acrylic resins, or a combination thereof. In further embodiments, the release layers comprise crosslinked polymers.

[0097] The protective layer can protect the organophotoreceptor from chemical and mechanical degradation. The protective layer may comprise any protective layer composition known in the art. In some embodiments, the protective layer is a fluorinated polymer, siloxane polymer, fluorosilicone polymer, polysilane, polyethylene, polypropylene, polyacrylate, poly(methyl methacrylate-co-methacrylic acid), urethane resins, urethane-epoxy resins, acrylated-urethane resins, urethane-acrylic resins, or a combination thereof. In some embodiments of particular interest, the release layers are crosslinked polymers.

[0098] An overcoat layer may comprise a charge transport material, such as an electron transport compound as described further in copending U.S. Patent Application Serial No. 10/396,536, filed on March 25, 2003 to Zhu et al. entitled, "Organoreceptor With An Electron Transport Layer," published as US 2003/0194626 A1, incorporated herein by reference. For example, an electron transport compound, as described above, may be used in the release layer of

this invention. The electron transport compound in the overcoat layer can be in an amount from about 2 to about 50 weight percent, and in other embodiments in an amount from about 10 to about 40 weight percent, based on the weight of the release layer. A person of ordinary skill in the art will recognize that additional ranges of composition within the explicit ranges are contemplated and are within the present disclosure.

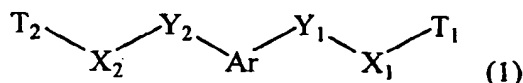
[0099] Generally, adhesive layers comprise a film forming polymer, such as polyester, polyvinylbutyral, polyvinylpyrrolidone, polyurethane, polymethyl methacrylate, poly(hydroxy amino ether) and the like. Barrier and adhesive layers are described further in U.S. Patent 6,180,305 to Ackley et al., entitled "Organic Photoreceptors for Liquid Electrophotography," incorporated herein by reference.

[0100] Sub-layers can comprise, for example, polyvinylbutyral, organosilanes, hydrolyzable silanes, epoxy resins, polyesters, polyamides, polyurethanes, and the like. In some embodiments, the sub-layer has a dry thickness between about 20 Angstroms and about 2,000 Angstroms. Sublayers containing metal oxide conductive particles can be between about 1 and about 25 microns thick. A person of ordinary skill in the art will recognize that additional ranges of compositions and thickness within the explicit ranges are contemplated and are within the present disclosure.

[0101] The charge transport materials as described herein, and photoreceptors including these compounds, are suitable for use in an imaging process with either dry or liquid toner development. For example, any dry toners and liquid toners known in the art may be used in the process and the apparatus of this invention. Liquid toner development can be desirable because it offers the advantages of providing higher resolution images and requiring lower energy for image fixing compared to dry toners. Examples of suitable liquid toners are known in the art. Liquid toners generally comprise toner particles dispersed in a carrier liquid. The toner particles can comprise a colorant/pigment, a resin binder, and/or a charge director. In some embodiments of liquid toner, a resin to pigment ratio can be from 1:1 to 10:1, and in other embodiments, from 4:1 to 8:1. Liquid toners are described further in Published U.S. Patent Applications 2002/0128349, entitled "Liquid Inks Comprising A Stable Organosol," 2002/0086916, entitled "Liquid Inks Comprising Treated Colorant Particles," and 2002/0197552, entitled "Phase Change Developer For Liquid Electrophotography," all three of which are incorporated herein by reference.

Charge Transport Material

[0102] As described herein, an organophotoreceptor comprises a charge transport material having the formula



where Y_1 and Y_2 are, each independently, a bond, $-\text{CR}_1=\text{N}-\text{NR}_2-$, or $-\text{CR}_3=\text{N}=\text{N}=\text{CR}_4-$ where R_1 , R_2 , R_3 , and R_4 comprise, each independently, H, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

X_1 and X_2 are, each independently, a linking group having the formula $-(\text{CH}_2)_m-$, branched or linear, where m is an integer between 0 and 20, inclusive, and one or more of the methylene groups is optionally replaced by O, S, C=O, O=S=O, a heterocyclic group, an aromatic group, urethane, urea, an ester group, an NR_5 group, a CHR_6 group, or a CR_7R_8 group where R_5 , R_6 , R_7 , and R_8 comprise, each independently, H, hydroxyl group, thiol group, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

T_1 and T_2 are, each independently, a thiiranyl group, H, an alkyl group, an alkenyl group, or an aromatic group with the proviso that at least one of T_1 and T_2 is a thiiranyl group; and

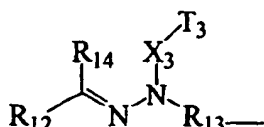
Ar comprises an aromatic group with the proviso that when both Y_1 and Y_2 are a bond and one of T_1 and T_2 is not a thiiranyl group, Ar comprises a bis[(N,N-disubstituted)amino]aromatic group or a bicarbazole group.

[0103] Preferably, T_2 is H, the m value for X_2 is 0, Y_2 is a bond, Y_1 is $-\text{CR}_1=\text{N}-\text{NR}_2-$ where the C atom is connected to Ar and the terminal N atom is connected to X_1 , and T_1 comprises a thiiranyl group.

[0104] Preferably, Ar comprises an arylamine group or an aromatic heterocyclic group.

[0105] Preferably, R_2 comprises an aromatic group.

[0106] Preferably, the aromatic group of R_2 has the formula



where R_{12} comprises an arylamine group, R_{13} is a linking group comprising an alkyl group, an alkenyl group, or

an aryl group, R_{14} comprises H, an alkyl group, an alkenyl group, or an aryl group, X_3 has the formula $-(CH_2)_m-$, branched or linear, where m is an integer between 1 and 20, and T_3 is a thiiranyl group.

[0107] Preferably, the m value for X_1 is 0, T_1 comprises an aromatic group, T_2 comprises a thiiranyl group, Y_2 is a bond, and Y_1 is $-CR_1=N-NR_2-$ where the C atom is connected to Ar and the terminal N atom is connected directly to T_1 .

[0108] Preferably, T_2 is H, the m value for X_2 is 0, Y_2 is a bond, Y_1 is $-CR_3=N-N=CR_4-$, and T_1 comprises a thiiranyl group.

[0109] Preferably, Y_1 and Y_2 are a bond and Ar comprises a bis[(N,N-disubstituted)amino]arylene group.

[0110] Preferably, T_2 is H, an alkyl group, an alkenyl group, or an aromatic group.

[0111] Preferably, Y_1 and Y_2 are a bond, Ar comprises two arylamine groups.

[0112] Preferably, Ar is a bicarbazole group.

[0113] Preferably, Ar comprises an arylamine group, Y_1 and Y_2 are each independently $-CR_1=N-NR_2-$, and T_1 and T_2 , each independently, comprise a thiiranyl group.

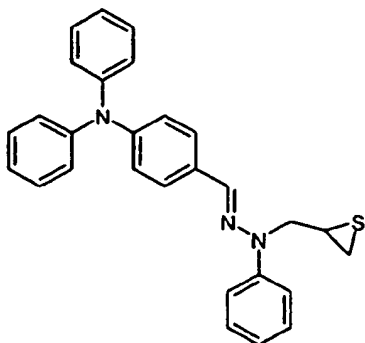
[0114] Preferably, the photoconductive element of the organophotoreceptor further comprises a second charge transport material.

[0115] Preferably, the second charge transport material comprises an electron transport compound.

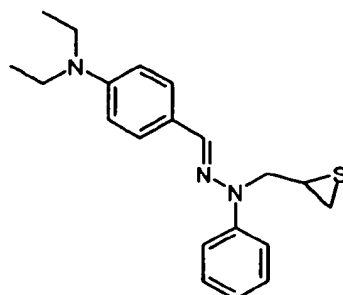
[0116] Preferably, the photoconductive element of the organophotoreceptor further comprises a binder.

[0117] In some embodiments, X_1 and X_2 are, each independently, a linking group having the formula $-(CH_2)_m-$, branched or linear, where m is an integer between 0 and 12, inclusive, especially between 0 and 6, inclusive, and one or more of the methylene groups is optionally replaced by O, S, C=O, O=S=O, a heterocyclic group, an aromatic group, urethane, urea, an ester group, an NR_5 group, a CHR_6 group, or a CR_7R_8 group where R_5 , R_6 , R_7 , and R_8 comprise, each independently, H, hydroxyl group, thiol group, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

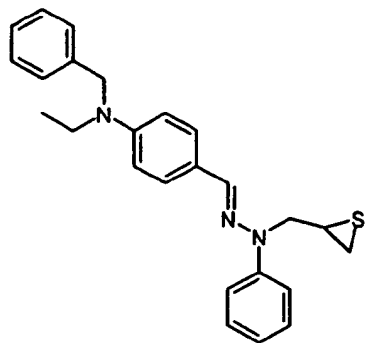
[0118] Specific, non-limiting examples of suitable charge transport materials within the general Formula (1) of the present invention have the following structures (2)-(11):



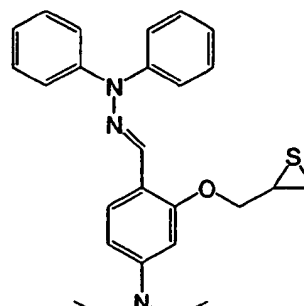
(2),



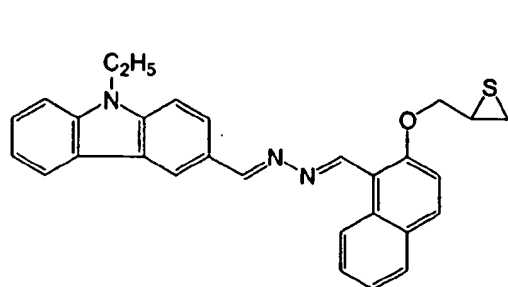
(3),



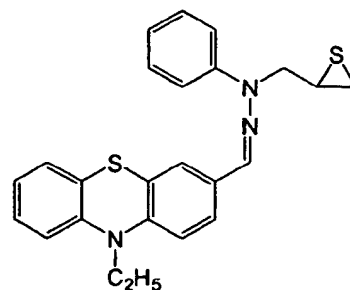
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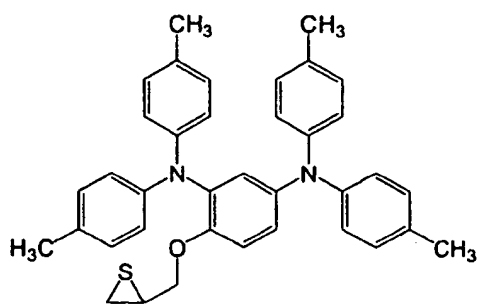
(5),



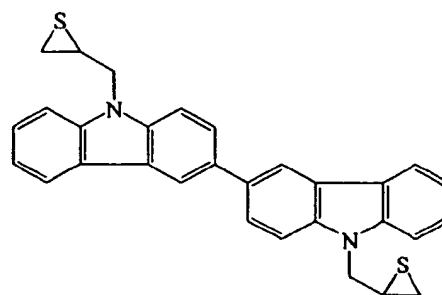
(6),



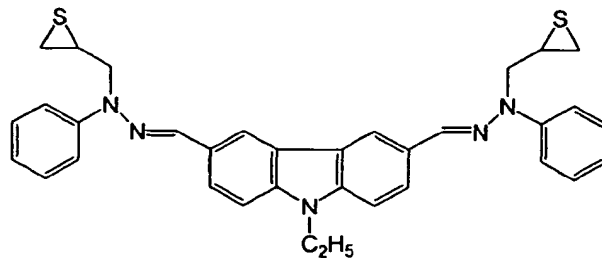
(7),



(8),

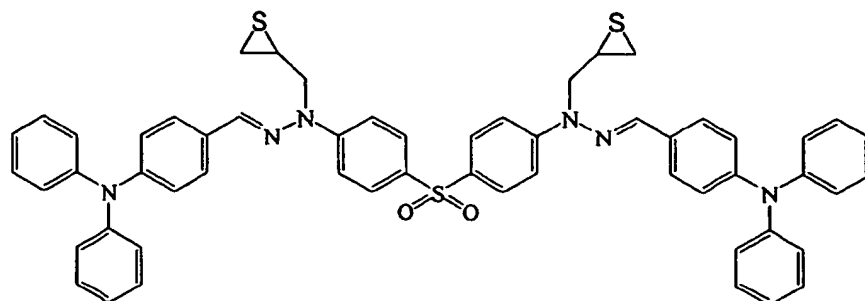


(9),



(10),

and



(11).

Synthesis Of Charge Transport Materials

[0119] The synthesis of the charge transport materials of this invention can be prepared by the following multi-step synthetic procedure, although other suitable procedures can be used by a person of ordinary skill in the art based on

the disclosure herein.

[0120] The first step is the synthesis of the epoxy analog of the targeted thiiranyl compound. The various preparations of suitable epoxy compounds for this invention have been disclosed in U.S. Patent Application numbers 10/634,164 (published as US 2004/0081903 A1), 10/695,581, 10/663,970 (published as US Patent No. 6768010), and 10/692,389, and U.S. Provisional Patent Application numbers 60/444,001 (of which US Application No. 10/749,164 published as US 2004/0157145 A1 claims the benefit) and 60/459,150 (of which US Application No. 10/772,068 published as US 2004/0161685 A1 claims the benefit). All the above application references are incorporated herein by reference. In the next step, the epoxy compounds react with ammonium thiocyanate in refluxing tetrahydrofuran (THF) to provide the corresponding thiiranyl compound of this invention. The thiiranyl compound is isolated and purified.

[0121] In addition to the procedures in the paragraph above, some charge transport materials of this invention can be prepared by reacting at least one aromatic aldehyde with a dihydrazine to form a dihydrazone. The dihydrazone can then react with an organic halide comprising an epoxy group to form the corresponding epoxy compound. Non-limiting examples of suitable organic halide comprising an epoxy group for this invention are epichlorohydrins, such as epichlorohydrin. The organic halide comprising an epoxy group can also be prepared by the epoxidation reaction of the corresponding organic halide having an olefin group. The epoxidation reaction is described in Carey et al., "Advanced Organic Chemistry, Part B: Reactions and Synthesis," New York, 1983, pp. 494-498, incorporated herein by reference. The organic halide having an olefin group can also be prepared by the Wittig reaction between a suitable organic halide having an aldehyde or keto group and a suitable Wittig reagent. The Wittig and related reactions are described in Carey et al., "Advanced Organic Chemistry, Part B: Reactions and Synthesis," New York, 1983, pp. 69-77, incorporated herein by reference. The epoxy compound then reacts with ammonium thiocyanate in refluxing tetrahydrofuran (THF) to provide the corresponding thiiranyl compound of this invention.

[0122] Some charge transport materials of this invention can also be prepared by reacting a bi-arylamine such as 3,3-bicarbazole with an organic halide comprising an epoxy group to form either a bi-arylamine with either one or two epoxy groups. The epoxy compound then reacts with ammonium thiocyanate in refluxing tetrahydrofuran (THF) to provide the corresponding thiiranyl compound of this invention.

[0123] The invention will now be described further by way of the following illustrative examples. These examples are to be viewed as being illustrative of specific materials falling within the broader disclosure presented above.

EXAMPLES

Example 1 - Synthesis And Characterization Charge Transport Materials

[0124] This example described the synthesis and characterization of Compounds (2)-(11) in which the numbers refer to formula numbers above. The characterization involves chemical characterization, and the electronic characterization of materials formed with the compounds are described in subsequent examples.

9-Ethyl-3-carbazolecarboxaldehyde N-2,3-epoxypropyl-N-phenylhydrazone

[0125] A mixture of potassium hydroxide powder (KOH, 85 %, 198 g, 3 mol,) and anhydrous sodium sulfate (Na_2SO_4 , 51 g, 0.369 mol) was added in three stages to a mixture of 9-ethylcarbazol-3-carbazolecarboxaldehyde-N-phenylhydrazone (313.4 g, 1 mol) and epichlorohydrin (1.5 mol), while keeping the reaction mixture at 20-25 °C: stage quantities added were 33 g of Na_2SO_4 and 66 g of KOH initially; 9.9g of Na_2SO_4 and 66 g of KOH after 1 hour of reaction; and 9.9 g of Na_2SO_4 and 66 g of KOH after 2 hours of reaction. The reaction mixture was stirred vigorously at 35-40 °C until the starting hydrazone disappeared (approximately 3-4 hours). Subsequently, the mixture was cooled to room temperature and any remaining solids were removed by filtration. The liquid organic phase was treated with diethyl ether and washed with distilled water until the washed water was of a neutral pH. The organic layer was dried over anhydrous magnesium sulfate, treated with activated charcoal, and filtered. The solvent and excess epichlorohydrin were removed by evaporation in a rotary evaporator. The residue was recrystallized from a mixture of toluene and 2-propanol in a 1:1 ratio by volume. The crystals formed upon standing were filtered off and washed with 2-propanol to give 290 g of product (78.5 % yield). The melting point was found to be 136-137 °C (recrystallized from toluene). The ^1H NMR spectrum (250 MHz) of the product in CDCl_3 was characterized by the following chemical shifts (δ , ppm): 8.35 (s, 1H, 4- H_{Ht}); 8.14 (d, $J=7.8$ Hz, 1H, 1- H_{Ht}); 7.93 (d, $J=7.6$ Hz, 1H, 2- H_{Ht}); 7.90 (s, 1H, $\text{CH}=\text{N}$); 7.54-7.20 (m, 8H, Ph, Ht); 6.96 (t, $J=7.2$ Hz, 1H, 4- H_{Ph}); 4.37 (m, 3H, CH_2CH_3 , one of the NCH_2 protons); 4.04 (dd, $J_1=4.3$ Hz, $J_2=16.4$ Hz, 1H, next of the NCH_2 protons); 3.32 (m, 1H, CH); 2.88 (dd, 1H, part of the ABX system, cis- H_A of CH_2O , $J_{\text{AX}}=2.6$ Hz, $J_{\text{AB}}=4.9$ Hz); 2.69 (dd, 1H, part of the ABX system, trans- H_B of CH_2O , $J_{\text{BX}}=4.0$ Hz); and 1.44 (t, $J=7.2$ Hz, 3H, CH_3). An elemental analysis yielded the following results in weight percent C 78.32, H 6.41, and N 11.55, which compared with calculated values for $\text{C}_{24}\text{H}_{23}\text{N}_3\text{O}$ in weight percent of C 78.02, H 6.28, and N 11.37.

4-(Diphenylamino)benzaldehyde N-2,3-epoxypropyl-N-phenylhydrazone

[0126] 4-(Diphenylamino)benzaldehyde N-2,3-epoxypropyl-N-phenylhydrazone was prepared according to the preparation procedure above for 9-ethyl-3-carbazolecarboxaldehyde N-2,3-epoxypropyl-N-phenylhydrazone except that 9-ethyl-3-carbazole-carboxaldehyde-N-phenylhydrazone was replaced by 4-(diphenylamino)benzaldehyde-N-phenylhydrazone (1 mol). The yield of 4-(diphenylamino)benzaldehyde N-2,3-epoxypropyl-N-phenylhydrazone was 377.1 g (89.9 %). The melting point was found to be 141-142.5 °C (recrystallized from toluene). The ¹H NMR spectrum (250 MHz) of the product in CDCl₃ was characterized by the following chemical shifts (δ, ppm): 7.65-6.98 (m, 19H, CH=N, Ar); 6.93 (t, J=7.2 Hz, 1H, 4-H_{Ph}); 4.35 (dd, 1H, part of the ABX system, H_A of NCH₂, J_{AX}=2.4 Hz, J_{AB}=16.4); 3.99 (dd, 1H, part of the ABX system, H_B of NCH₂, J_{BX}=4.1 Hz); 3.26 (m, 1H, CH); 2.84 (dd, 1H, part of the ABX system, cis-H_A of CH₂O, J_{AX}=2.7 Hz, J_{AB}=4.8 Hz); and 2.62 (dd, 1H, part of the ABX system, trans-H_B of CH₂O, J_{BX}=4.1 Hz). An elemental analysis yielded the following results in weight percent C 80.02, H 6.31, and N 9.91, which compared with calculated values for C₂₈H₂₅N₃O in weight percent of C 80.16, H 6.01, and N 10.02.

4-Diethylaminobenzaldehyde N-2,3-epoxypropyl-N-phenylhydrazone

[0127] A mixture of potassium hydroxide powder (KOH, 85 %, 198 g, 3 mol,) and anhydrous sodium sulfate (Na₂SO₄, 51 g, 0.369 mol) was added in three stages to a mixture of 4-(diethylamino)benzaldehyde N-phenylhydrazone (267.4 g, 1 mol) and epichlorohydrin (1.5 mol), while keeping the reaction mixture at 20-25 °C: stage quantities added were 33 g of Na₂SO₄ and 66 g of KOH initially; 9.9g of Na₂SO₄ and 66 g of KOH after 1 hour of reaction; and 9.9 g of Na₂SO₄ and 66 g of KOH after 2 hours of reaction. The reaction mixture was stirred vigorously at 35-40 °C until the starting hydrazone disappeared (approx. 4-5 hours). Subsequently, the mixture was cooled to room temperature, and the solids were removed by filtration. The liquid organic phase was treated with diethyl ether and washed with distilled water until the washed water was neutral. The organic layer was dried over anhydrous magnesium sulfate, treated with activated charcoal, and filtered. The solvent and excess epichlorohydrin were removed by evaporation in a rotary evaporator. The residue was recrystallized from diethyl ether and the crystals that formed upon standing were filtered off and washed with 2-propanol to give 260 g of the product (80.4 % yield). The melting point was found to be 79-80.5 °C (recrystallized from diethyl ether). The ¹H NMR spectrum (250 MHz) of the product in CDCl₃ was characterized by the following chemical shifts (δ, ppm): 7.7-6.7 (m, 8H, Ar, CH=N); 6.6 (d, 2H, 2-H, 6-H of *p*-Ph); 4.4-3.6 (m, 2H, NCH₂CH); 3.6-3.0 (m, 5H, CH₂CH₃, CH₂CH₂CH₂); 2.75 (m, 1H, ABX, cis-H_A of CH₂O); 2.55 (m, ABX, trans-H_B of CH₂O); and 1.1 (t, J=7.0 Hz, 6H, CH₃).

4-(N-ethyl-N-benzylamino)benzaldehyde N-2,3-epoxypropyl-N-phenylhydrazone

[0128] 4-(N-ethyl-N-benzylamino)benzaldehyde N-2,3-epoxypropyl-N-phenylhydrazone was made similarly to 9-ethyl-3-carbazolecarboxaldehyde N-2,3-epoxypropyl-N-phenylhydrazone except that N-ethyl-N-benzylaminobenzaldehyde (329.4 g, 1 mol) replaced 9-ethyl-3-carbazolecarboxaldehyde. The epoxide was isolated by analogy to N-ethyl-3-carbazolecarboxaldehyde N-2,3-epoxypropyl-N-phenylhydrazone except that column chromatography (using silica gel, grade 62, 60-200 mesh, 150 Angstrom, obtained from Aldrich) using a mixture of ether and hexane in a 1:2 ratio by volume as eluant was used as an additional purification step. The solvent was removed by evaporation in a rotary evaporator to yield an oily 4-(N-ethyl-N-benzylamino)benzaldehyde N-2,3-epoxypropyl-N-phenylhydrazone (310 g, 80.4 % yield). The ¹H NMR spectrum (400 MHz) of the product in CDCl₃ was characterized by the following chemical shifts (δ, ppm): 7.70 (s, 1H, CH=N); 7.55 (d, 2H, J=8.8 Hz, 2,6-H_{*p*-Ph}); 7.16-7.41 (m, 4H, Ar); 6.93 (t, 1H, J=7.3 Hz, 4-H_{*p*-Ph}); 6.69 (d, 2H, J=8.8 Hz, 3,5-H_{*p*-Ph}); 4.58 (s, 2H, CH₂Ph); 4.37 (dd, 1H, ABX, J_{AB}=16.2, J_{AX}=2.4 Hz, H_A of NCH₂); 3.99 (dd, 1H, ABX, J_{BX}=4.1 Hz, H_B of NCH₂); 3.28 (m, 1H, CH_X); 3.53 (q, 2H, J=7.3 Hz, CH₂CH₃); 2.84 (dd, 1H, ABX, J_{AB}=4.8 Hz, J_{AX}=2.7 Hz, *cis*-H_A of CH₂O); 2.62 (dd, 1H, ABX, J_{BX}=4.0 Hz, *trans*-H_B of CH₂O); and 1.24 (t, J=7.3 Hz, 3H, CH₂CH₃).

Compound (2)

[0129] 4-(Diphenylamino)benzaldehyde-N-(2,3-epoxypropyl)-N-phenylhydrazone (17 g, 40.5 mmole), ammonium thiocyanate (10 g, 0.13 mole, obtained from Aldrich), and 40 ml of tetrahydrofuran (THF) were added to a 100 ml, 3-neck round bottom flask equipped with a reflux condenser and a magnetic stirrer. The mixture was refluxed for 2 hours. The solvent was removed by evaporation, and the residue was subjected to liquid chromatography (using silica gel, grade 62, 60-200 mesh, 150 Angstrom, obtained from Aldrich) using a mixture of acetone and hexane in a 1:4 ratio by volume as eluant. Fractions containing the product were collected, and the solvent was evaporated. The residue was recrystallized from benzene. The solid was filtered off and washed with isopropanol. The yield was 12 g (68%). The ¹H NMR spectrum (100 MHz) of the product in CDCl₃ was characterized by the following chemical shifts (δ, ppm):

7.54 (s, 1H, CH=N); 7.50-6.90 (m, 19H, Ar); 5.06 (p, 1H, CH); 4.19 (d, 2H, NCH₂); and 3.72-3.32 (m, 2H, SCH₂). An elemental analysis yielded the following results in weight percent C 77.12, H 5.66, and N 9.49, which compared with calculated values for C₂₈H₂₅N₃S in weight percent of C 77.21, H 5.79, and N 9.65.

5 Compound (3)

[0130] 4-(Diethylamino)benzaldehyde-N-(2,3-epoxypropyl)-N-phenylhydrazone (13.2 g, 40.5 mmole), ammonium thiocyanate (10 g, 0.13 mole, obtained from Aldrich), and 40 ml of tetrahydrofuran (THF) were added to a 100 ml, 3-neck round bottom flask equipped with a reflux condenser and a magnetic stirrer. The mixture was refluxed for 2 hours. The solvent was removed by evaporation and the residue was subjected to liquid chromatography (using silica gel, grade 62, 60-200 mesh, 150 Angstrom, obtained from Aldrich) using a mixture of acetone and hexane in a 1:4 ratio by volume as eluant. Fractions containing the product were combined, and the solvent was evaporated. Diethyl ether was added to the oily residue to make a 20 weight % product solution in ether. The ether solution was poured with intensive stirring into a 10-fold excess of ethanol. The solid product that formed was filtered off and dried in vacuum oven at 50 °C for 8 hours. The yield was 7.2 g (52%). The ¹H NMR spectrum (400 MHz) of the product in CDCl₃ was characterized by the following chemical shifts (δ, ppm): 7.72 (s, 1H, CH=N); 7.58 (d, J=8.8 Hz, 2H, 2,6-H of p-Ph); 7.41-7.28 (m, 4H, Ar); 6.93 (dd, 1H, 4-H Ph); 6.69 (d, J=8.8 Hz, 2H, 3,5-H of p-Ph); 4.25 (dd, 1H, ABX, one (H_A) of NCH₂, J_{AB}=16.1 Hz, J_{AX}=6.6 Hz); 4.05 (dd, 1H, ABX, one (H_B) of NCH₂, J_{BX}=5.1 Hz); 3.39 (q, J=7.3 Hz, 4H, CH₂CH₃); 3.19 (p, 1H, J=5.9 Hz, CHS); 2.55 (dd, 1H, ABX, trans proton (H_B) of SCH₂, J_{AB}=1.3 Hz, J_{BX}=5.9 Hz); 2.39 (dd, 1H, ABX, cis proton (H_A), SCH₂, J_{AX}=5.0 Hz); and 1.19 (t, J=7.3 Hz, 3H, CH₃). An elemental analysis yielded the following results in weight percent C 74.64, H 5.96, and N 10.99, which compared with calculated values for C₂₀H₂₅N₃S in weight percent of C 70.76, H 7.42, and N 9.44.

25 Compound (4)

[0131] 4-(N-Benzyl-N-ethylamino)benzaldehyde-N-(2,3-epoxypropyl)-N-phenylhydrazone (15.7 g, 40.5 mmole), ammonium thiocyanate (10 g, 0.13 mole, obtained from Aldrich), and 40 ml of tetrahydrofuran (THF) were added to a 100 ml, 3-neck round bottom flask equipped with a reflux condenser and a magnetic stirrer. The mixture was refluxed for 2 hours. The solvent was removed by evaporation, and the residue was subjected to liquid chromatography (using silica gel, grade 62, 60-200 mesh, 150 Angstrom, obtained from Aldrich) using a mixture of acetone and hexane in a 1:4 ratio by volume as eluant. Fractions containing the product were combined, and the solvent was evaporated. The yield of the oily product was 11.4 g (70%). The ¹H NMR spectrum (400 MHz) of the product in CDCl₃ was characterized by the following chemical shifts (δ, ppm): 7.70 (s, 1H, CH=N); 7.55 (d, J=8.8 Hz, 2H, 2,6-H of p-Ph); 7.41-7.16 (m, 4H, Ar); 6.93 (dd, 1H, 4-H Ph); 6.69 (d, J=8.8 Hz, 2H, 3,5-H of p-Ph); 4.58 (s, 2H, CH₂Ph); 4.24 (dd, 1H, ABX, one (H_A) of NCH₂, J_{AB}=16.1 Hz, J_{AX}=6.6 Hz); 4.05 (dd, 1H, ABX, one (H_B) of NCH₂, J_{BX}=5.1 Hz); 3.53 (q, J=7.3 Hz, 4H, CH₂CH₃); 3.18 (p, 1H, J=5.9 Hz, CHS); 2.54 (dd, 1H, ABX, trans proton (H_B) of SCH₂, J_{AB}=1.3 Hz, J_{BX}=5.9 Hz); 2.38 (dd, 1H, ABX, cis proton (H_A), SCH₂, J_{AX}=5.0 Hz); and 1.24 (t, J=7.3 Hz, 3H, CH₃). An elemental analysis yielded the following results in weight percent: C 74.64; H 6.66; N 10.39, which compared with calculated values for C₂₅H₂₇N₃S in weight percent of: C 74.77; H 6.78; N 10.46.

40 Compound (5)

[0132] Compound (5) can be prepared according to the preparation procedure for Compound (2) except that 4-(diphenylamino)benzaldehyde-N-(2,3-epoxypropyl)-N-phenylhydrazone is replaced with Compound (2) of U.S. Provisional Patent Application number 60/444,001, incorporated herein by reference.

Compound (6)

[0133] Compound (6) can be prepared according to the preparation procedure for Compound (2) except that 4-(diphenylamino)benzaldehyde-N-(2,3-epoxypropyl)-N-phenylhydrazone is replaced with Compound (2) of U.S. Patent Application number 10/663,970, incorporated herein by reference.

Compound (7)

[0134] Compound (7) can be prepared according to the preparation procedure for Compound (2) except that 4-(diphenylamino)benzaldehyde-N-(2,3-epoxypropyl)-N-phenylhydrazone is replaced with Compound (2) of U.S. Patent Application number 10/695,581, incorporated herein by reference.

Compound (8)

[0135] Compound (8) can be prepared according to the preparation procedure for Compound (2) except that 4-(diphenylamino)benzaldehyde-N-(2,3-epoxypropyl)-N-phenylhydrazone is replaced with Compound (2) of U.S. Patent Application number 10/692,389, incorporated herein by reference.

Compound (9)

[0136] 9-(2,3-Epoxy-propyl)carbazole (2.2 g, 0.01 mol, obtained from BIOLAR, str. Rupnicu 3, Olaine LV-2114, Latvia), 80 ml of chloroform, and, after dissolution, anhydrous ferric chloride (FeCl_3 , 6.5g, 0.04 mol, obtained from Aldrich) were added to a 100 ml, 3-neck round bottom flask equipped with a reflux condenser and a magnetic stirrer. The reaction mixture was intensively stirred under argon atmosphere at room temperature until 9-(2,3-epoxypropyl)carbazole completely reacted (20 minutes, as determined by thin layer chromatography using a mixture of acetone and hexane in a ratio of 7:18 by volume as the mobile phase). The reaction mixture was diluted with 150 ml of acetone, treated with 250 ml of ethyl acetate, washed three times with HCl solution (0.5 M, 100 ml), and washed with distilled water until the wash water was neutral. The organic layer was dried over anhydrous MgSO_4 , treated with activated charcoal, and filtered. Then, the solvents were removed by evaporation. The crude product was recrystallized from toluene and washed repeatedly with 2-propanol to afford 2.07 g (80.4% yield) of the 9-(3-chloro-2-hydroxypropyl)-3,3'-bicarbazyle. The product had a melting point of 152-153°C (recrystallized from toluene). The IR spectrum of the product in a KBr salt window displayed the following characteristic bonds, $\nu(\text{cm}^{-1})$: 3642-3071 (OH), 3042, 3028 (CH_A), and 2942, 2914 (CH_B). The ^1H NMR spectrum (250 MHz) of the product in CDCl_3 was characterized by the following chemical shifts (δ , ppm): 8.37 (s, 2H, 5- H_{Ht}); 8.17 (d, $J=7.8$ Hz, 2H, 4- H_{Ht}); 7.80 (d, $J=8.4$ Hz, 2H, 6- H_{Ht}); 7.70-7.1 (m, 8H, Ht); 4.46 (m, 6H, NCH_2 , CHOH); 3.73-3.63 (dd, 2H, one of CH_2Cl protons, H_A , $J_{AX}=5.0$ Hz, $J_{AB}=11.4$ Hz); 3.63-3.53 (dd, 2H, another of CH_2Cl protons, H_B , $J_{BX}=4.6$ Hz); and 2.40 (s, 2H, OH). An elemental analysis yielded the following results in weight percent C 69.52, H 5.11, and N 5.43, which compared with calculated values for $\text{C}_{30}\text{H}_{24}\text{N}_2\text{O}_2$ in weight percent of C 69.64, H 5.06, and N 5.41.

[0137] 9-(3-Chloro-2-hydroxypropyl)-3,3'-bicarbazyle (3.0 g, 5.8 mmol), 60 ml of 1,4-dioxane, and, after dissolution, powdered potassium hydroxide (85%, 2.3g, 34.8 mmol) were added to a 100 ml, 3-neck round bottom flask equipped with a reflux condenser and a magnetic stirrer. The reaction mixture was stirred intensively for 30 minutes until the reaction was completed (as determined by thin layer chromatography using a mixture of acetone and hexane in a ratio of 7:18 by volume as the mobile phase), and then the mixture was filtered to remove any solids. The liquid organic phase was treated with ethyl acetate and washed with distilled water until the wash water was neutral. The organic layer was dried over anhydrous MgSO_4 , and the solvent removed by evaporation. The residue was recrystallized from toluene. The crystals were harvested by filtration, washed repeatedly with 2-propanol, and dried under vacuum. The yield of 9-(2,3-epoxypropyl)-3,3'-bicarbazyle was 2.1 g (81.4%), and the product had a melting point of 173.5-175.5°C (recrystallized from toluene). The IR spectrum of the product in a KBr salt window displayed the following characteristic bonds, $\nu(\text{cm}^{-1})$: 3071, 3042 (CH_A); 2971, 2942 (CH_B); 1256, 1218, 855, 801, 794 (epoxy ring). The ^1H NMR spectrum (250 MHz) of the product in CDCl_3 was characterized by the following chemical shifts (δ , ppm): 8.39 (s, 2H, 5- H_{Ht}); 8.17 (d, $J=7.9$ Hz, 2H, 4- H_{Ht}); 7.82 (d, $J=8.5$ Hz, 2H, 6- H_{Ht}); 7.70-7.1 (m, 8H, Ht); 4.70-4.60 (dd, 2H, one of NCH_2 protons, H_A , $J_{AX}=3.2$ Hz, $J_{AB}=15.8$ Hz); 4.50-4.33 (dd, 2H, another of NCH_2 protons, H_B , $J_{BX}=4.7$ Hz); 3.38 (m, 2H, CH); 2.82 (dd, 2H, one of OCH_2 protons, H_A , $J_{AX}=4.3$ Hz, $J_{AB}=4.8$ Hz); and 2.65-2.55 (dd, 2H, another of OCH_2 protons, H_B , $J_{BX}=2.7$ Hz). An elemental analysis yielded the following results in weight percent C 80.89, H 5.48, and N 6.11, which compared with calculated values for $\text{C}_{30}\text{H}_{24}\text{N}_2\text{O}_2$ in weight percent of C 81.06, H 5.44, and N 6.03.

[0138] Compound (9) can be prepared by adding 9-(2,3-Epoxypropyl)-3,3'-bicarbazyle (9 g, 20.25 mmole), ammonium thiocyanate (5 g, 65 mmole, obtained from Aldrich) and 20 ml of tetrahydrofuran (THF) to a 50 ml 3-neck round bottom flask equipped with a reflux condenser and a magnetic stirrer. The mixture is refluxed for 2 hours. The solvent is evaporated and the product is purified by liquid chromatography.

Compound (10)

[0139] Compound (10) can be prepared according to the preparation procedure for Compound (2) except that 4-(diphenylamino)benzaldehyde-N-(2,3-epoxypropyl)-N-phenylhydrazone is replaced with Compound (9) of U.S. Patent Application number 10/634164, incorporated herein by reference.

Compound (11)

[0140] 4,4'-Dichlorodiphenyl sulfone (20g, 0.069 mol, obtained from Aldrich) and hydrazine monohydrate (98 %, 158 ml, obtained from Aldrich) were added to a 250 ml 3-neck round bottom flask equipped with a reflux condenser and a

magnetic stirrer. The suspension was refluxed for 24 hours and then cooled to room temperature. The crystals that formed upon standing were collected by filtration, washed 3 times with water, and once with isopropanol. The yield of 4,4'-dihydrazinodiphenyl sulfone was 15.75g (81.8%). The product had a melting point of 193-194 °C.

[0141] 4-(diphenylamino)benzaldehyde (25 g, 0.09 mol, obtained from Aldrich) and 4,4'-dihydrazinodiphenyl sulfone (11.37g, 0.041 mol) dissolved in 80 ml of dioxane were added to a 250 ml round bottom flask equipped with a reflux condenser and magnetic stirrer. The reaction mixture was heated to 50 °C and stirred intensively for 2 h. The solution was distilled to obtain 30.1g (93.4% yield) of 4,4'-dihydrazondiphenyl sulfone.

[0142] 4,4'-dihydrazondiphenyl sulfone (30.1 g 0.038 mol) and epichlorohydrin (68 ml, 0.855 mol, obtained from Aldrich) were added to a 250 ml 3-neck round bottom flask equipped with a reflux condenser, thermometer, and magnetic stirrer. The reaction mixture was stirred vigorously at 35-40 °C for 7 hours, during which time powdered potassium hydroxide (85 %, 11.3 g, 0.171 mol) and anhydrous Na₂SO₄ (2.9 g, 0.0228 mol) were added in three portions with prior cooling of the reaction mixture to 20-25°C. Upon completion of the reaction, the mixture was cooled to room temperature, and solids were removed by filtration. The liquid organic phase was treated with ethyl acetate and washed with distilled water until the wash water was neutral. The organic layer was then dried over anhydrous magnesium sulfate, treated with activated charcoal, filtered, and solvents were removed by evaporation. The di-epoxy compound was purified by column chromatography (silica gel, grade 62, 60-200 mesh, 150 Å, Aldrich) using 1:4 acetone:hexane as the eluant to obtain 19.3 g (56 % yield) of the diepoxide of 4,4'-dihydrazondiphenyl sulfone. The melting point was found to be 223-225 °C (recrystallized from a mixture of acetone and hexane in a ratio of 1:4.). The ¹H NMR spectrum (100 MHz) of the product in CDCl₃ was characterized by the following chemical shifts (δ, ppm): 8.0-6.8 (m, 38H, CH=N, Ar); 4.5-4.3 (dd, 2H, one proton of NCH₂); 4.1-3.8 (dd, 2H, another proton of NCH₂); 3.2 (m, 2H, CH); 2.9-2.8 (dd, 2H, one proton of OCH₂); and 2.7-2.5 (dd, another proton of OCH₂). An elemental analysis yielded the following results in weight percent: C 74.71, H 5.33, and N 9.45, which compared with calculated values for C₃₈H₃₅N₅O₂ in weight percent of C 74.64, H 5.37, and N 9.33.

[0143] Compound (11) can be prepared by adding diepoxide of 4,4'-dihydrazondiphenyl sulfone (36.5 g, 40.5 mmole), ammonium thiocyanate (10 g, 0.13 mole, obtained from Aldrich) and 40 ml of tetrahydrofuran (THF) to a 100 ml 3 neck round bottom flask equipped with a reflux condenser and a magnetic stirrer. The mixture is refluxed for 2 hours. The solvent is evaporated, and the product is purified by liquid chromatography.

Example 2 - Charge Mobility Measurements

[0144] This example describes the measurement of charge mobility for charge transport materials, specifically Compound (2) as described above.

Sample 1

[0145] Sample 1 was prepared by dissolving a mixture of 0.1 g of the Compound (2) and 0.1 g of polyvinylbutyral (S-LEC B BX-1, commercially obtained from Sekisui) in 2 ml of tetrahydrofuran. The solution was coated on a polyester film with conductive aluminum layer by a dip roller. After the coating was dried for 1 hour at 80°C, a clear 10 μm thick layer was formed. The hole mobility of the sample was measured and the results are presented in Table 1.

Sample 2

[0146] Sample 2 was prepared and tested similarly as Sample 1, except polycarbonate Z-200 (from Mitsubishi Gas Chemical) was used instead of polyvinylbutyral.

Mobility Measurements

[0147] Each sample was corona charged positively up to a surface potential U and illuminated with 2 ns long nitrogen laser light pulse. The hole mobility μ was determined as described in Kalade et al., "Investigation of charge carrier transfer in electrophotographic layers of chalcogenide glasses," Proceeding IPCS 1994: The Physics and Chemistry of Imaging Systems, Rochester, NY, pp. 747-752, incorporated herein by reference. The hole mobility measurement was repeated with changes to the charging regime to charge the sample to different U values, which corresponded to different electric field strength, E, inside the layer. This dependence on electric field strength was approximated by the formula

$$\mu = \mu_0 e^{\alpha \sqrt{E}}$$

Here E is electric field strength, μ_0 is the zero field mobility and α is Pool-Frenkel parameter. Table 1 lists the mobility characterizing parameters μ_0 and α values and the mobility value at the 6.4×10^5 V/cm field strength as determined from these measurements.

Table 1.

Sample	μ_0 (cm ² /V·s)	μ (cm ² /V·s) at $6.4 \cdot 10^5$ V/cm	α (cm/V) ^{0.5}	Ionization Potential (eV)
Sample 1 (Compound 2)	8×10^{-10}	4.7×10^{-9}	0.0022	5.48
Sample 2 (Compound 2)	3×10^{-8}	2.2×10^{-6}	0.0054	

Example 3 - Ionization Potential Measurements

[0148] This example describes the measurement of the ionization potential for the charge transport materials, specifically Compound (2) described in Example 1.

[0149] To perform the ionization potential measurements, a thin layer of charge transport material about 0.5 μm thickness was coated from a solution of 2 mg of charge transport material in 0.2 ml of tetrahydrofuran on a 20 cm² substrate surface. The substrate was polyester film with an aluminum layer over a methylcellulose sublayer of about 0.4 μm thickness.

[0150] Ionization potential was measured as described in Grigalevicius et al., "3,6-Di(N-diphenylamino)-9-phenyl-carbazole and its methyl-substituted derivative as novel hole-transporting amorphous molecular materials," *Synthetic Metals* **128** (2002), p. 127-131, incorporated herein by reference. In particular, each sample was illuminated with monochromatic light from the quartz monochromator with a deuterium lamp source. The power of the incident light beam was $2.5 \cdot 10^{-8}$ W. A negative voltage of -300 V was supplied to the sample substrate. A counter-electrode with the 4.5×15 mm² slit for illumination was placed at 8 mm distance from the sample surface. The counter-electrode was connected to the input of a BK2-16 type electrometer, working in the open input regime, for the photocurrent measurement. A 10^{-15} - 10^{-12} amp photocurrent was flowing in the circuit under illumination. The photocurrent, I , was strongly dependent on the incident light photon energy $h\nu$. The $I^{0.5} = f(h\nu)$ dependence was plotted. Usually, the dependence of the square root of photocurrent on incident light quanta energy is well described by linear relationship near the threshold (see references "Ionization Potential of Organic Pigment Film by Atmospheric Photoelectron Emission Analysis," *Electrophotography*, **28**, Nr. 4, p. 364 (1989) by E. Miyamoto, Y. Yamaguchi, and M. Yokoyama; and "Photoemission in Solids," *Topics in Applied Physics*, **26**, 1-103 (1978) by M. Cordona and L. Ley, both of which are incorporated herein by reference). The linear part of this dependence was extrapolated to the $h\nu$ axis, and the I_p value was determined as the photon energy at the interception point. The ionization potential measurement has an error of ± 0.03 eV. Table 1 lists the ionization potential value of Compound (2).

[0151] As understood by those skilled in the art, additional substitution, variation among substituents, and alternative methods of synthesis and use may be practiced within the scope and intent of the present disclosure of the invention. The embodiments above are intended to be illustrative and not limiting. Additional embodiments are within the claims. Although the present invention has been described with reference to particular embodiments, workers skilled in the art will recognize that changes may be made in form and detail without departing from the spirit and scope of the invention.

[0152] Although a few preferred embodiments have been shown and described, it will be appreciated by those skilled in the art that various changes and modifications might be made without departing from the scope of the invention, as defined in the appended claims.

[0153] Attention is directed to all papers and documents which are filed concurrently with or previous to this specification in connection with this application and which are open to public inspection with this specification, and the contents of all such papers and documents are incorporated herein by reference.

[0154] All of the features disclosed in this specification (including any accompanying claims, abstract and drawings), and/or all of the steps of any method or process so disclosed, may be combined in any combination, except combinations where at least some of such features and/or steps are mutually exclusive.

[0155] Each feature disclosed in this specification (including any accompanying claims, abstract and drawings) may be replaced by alternative features serving the same, equivalent or similar purpose, unless expressly stated otherwise. Thus, unless expressly stated otherwise, each feature disclosed is one example only of a generic series of equivalent or similar features.

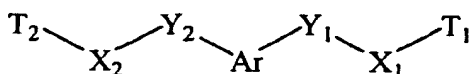
[0156] The invention is not restricted to the details of the foregoing embodiment(s). The invention extends to any

novel one, or any novel combination, of the features disclosed in this specification (including any accompanying claims, abstract and drawings), or to any novel one, or any novel combination, of the steps of any method or process so disclosed.

Claims

1. An organophotoreceptor comprising an electrically conductive substrate and a photoconductive element on the electrically conductive substrate, the photoconductive element comprising:

(a) a charge transport material having the formula



where Y_1 and Y_2 are, each independently, a bond, $-CR_1=N-NR_2-$, or $-CR_3=N-N=CR_4-$ where R_1 , R_2 , R_3 , and R_4 comprise, each independently, H, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

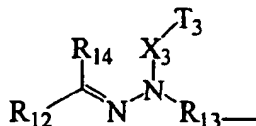
X_1 and X_2 are, each independently, a linking group having the formula $-(CH_2)_m-$, branched or linear, where m is an integer between 0 and 20, inclusive, and one or more of the methylene groups is optionally replaced by O, S, C=O, O=S=O, a heterocyclic group, an aromatic group, urethane, urea, an ester group, an NR_5 group, a CHR_6 group, or a CR_7R_8 group where R_5 , R_6 , R_7 , and R_8 comprise, each independently, H, hydroxyl group, thiol group, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

T_1 and T_2 are, each independently, a thiiranyl group, H, an alkyl group, an alkenyl group, or an aromatic group with the proviso that at least one of T_1 and T_2 is a thiiranyl group; and

Ar comprises an aromatic group with the proviso that when both Y_1 and Y_2 are a bond and one of T_1 and T_2 is not a thiiranyl group, Ar comprises a bis[(N,N-disubstituted)amino]aromatic group or a bicarbazole group; and

(b) a charge generating compound.

2. An organophotoreceptor according to claim 1 wherein T_2 is H, the m value for X_2 is 0, Y_2 is a bond, Y_1 is $-CR_1=N-NR_2-$ where the C atom is connected to Ar and the terminal N atom is connected to X_1 , and T_1 comprises a thiiranyl group.
3. An organophotoreceptor according to claim 2 wherein Ar comprises an arylamine group or an aromatic heterocyclic group.
4. An organophotoreceptor according to either of claims 2 and 3 wherein R_2 comprises an aromatic group.
5. An organophotoreceptor according to claim 4 wherein the aromatic group of R_2 has the formula

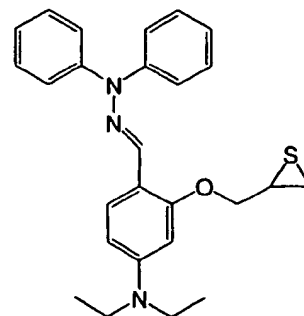
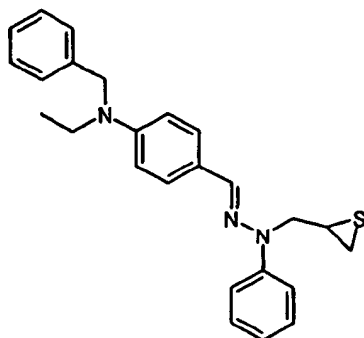
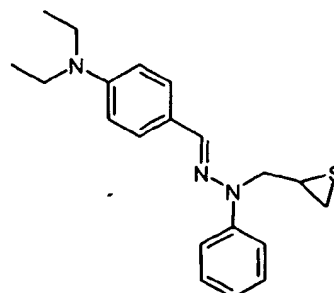
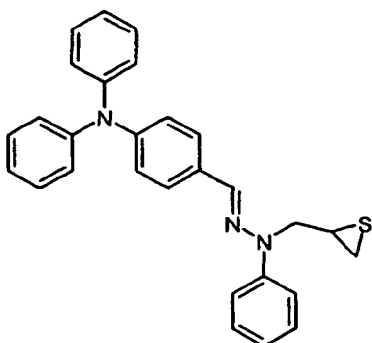


where R_{12} comprises an arylamine group, R_{13} is a linking group comprising an alkyl group, an alkenyl group, or an aryl group, R_{14} comprises H, an alkyl group, an alkenyl group, or an aryl group, X_3 has the formula $-(CH_2)_m-$, branched or linear, where m is an integer between 1 and 20, and T_3 is a thiiranyl group.

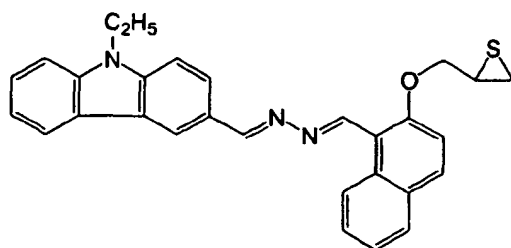
6. An organophotoreceptor according to claim 1 wherein the m value for X_1 is 0, T_1 comprises an aromatic group, T_2 comprises a thiiranyl group, Y_2 is a bond, and Y_1 is $-CR_1=N-NR_2-$ where the C atom is connected to Ar and the terminal N atom is connected directly to T_1 .
7. An organophotoreceptor according to claim 6 wherein Ar comprises an arylamine group or an aromatic heterocyclic

group.

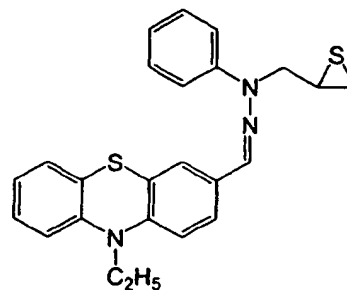
8. An organophotoreceptor according to claim 1 wherein T_2 is H, the m value for X_2 is 0, Y_2 is a bond, Y_1 is $-\text{CR}_3=\text{N}=\text{CR}_4-$, and T_1 comprises a thiiranyl group.
9. An organophotoreceptor according to claim 8 wherein Ar comprises an arylamine group or an aromatic heterocyclic group.
10. An organophotoreceptor according to claim 1 wherein Y_1 and Y_2 are a bond and Ar comprises a bis[(N,N-disubstituted)amino]arylene group.
11. An organophotoreceptor according to claim 10 wherein T_2 is H, an alkyl group, an alkenyl group, or an aromatic group.
12. An organophotoreceptor according to claim 1 wherein Y_1 and Y_2 are a bond, Ar comprises two arylamine groups.
13. An organophotoreceptor according to claim 12 wherein Ar is a bicarbazole group.
14. An organophotoreceptor according to claim 1 wherein Ar comprises an arylamine group, Y_1 and Y_2 are each independently $-\text{CR}_1=\text{N}=\text{NR}_2-$, and T_1 and T_2 , each independently, comprise a thiiranyl group.
15. An organophotoreceptor according to claim 1 wherein the charge transport material is selected from the group consisting of the following formulae:



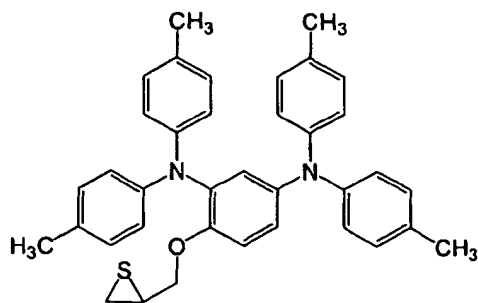
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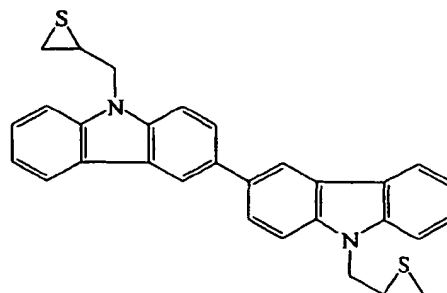
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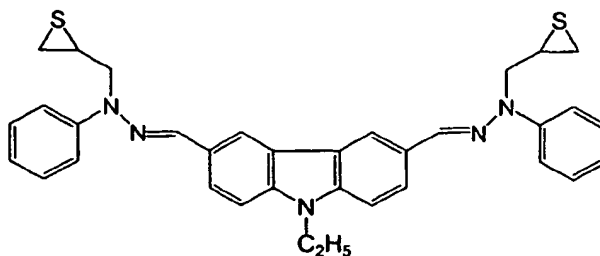


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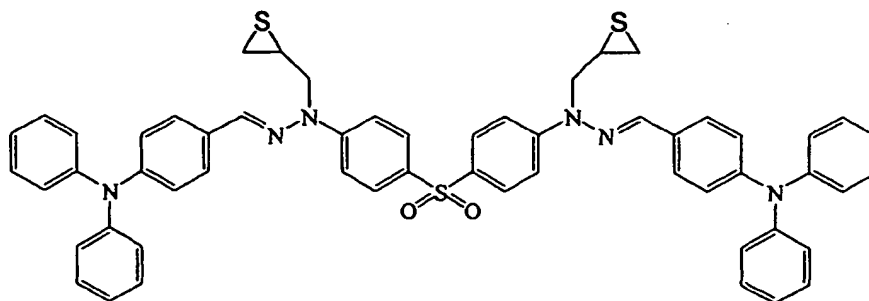


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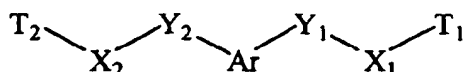


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16. An organophotoreceptor according to any preceding claim wherein the photoconductive element further comprises a second charge transport material.

17. An organophotoreceptor according to claim 16 wherein the second charge transport material comprises an electron transport compound.
18. An organophotoreceptor according to any preceding claim wherein the photoconductive element further comprises a binder.
19. An electrophotographic imaging apparatus comprising:
- (a) a light imaging component; and
 - (b) an organophotoreceptor oriented to receive light from the light imaging component, the organophotoreceptor comprising an electrically conductive substrate and a photoconductive element on the electrically conductive substrate, the photoconductive element comprising:
 - (i) a charge transport material as defined in any of claims 1 to 15; and
 - (ii) a charge generating compound.
20. An electrophotographic imaging apparatus according to claim 19 wherein the photoconductive element further comprises a second charge transport material.
21. An electrophotographic imaging apparatus according to claim 20 wherein second charge transport material comprises an electron transport compound.
22. An electrophotographic imaging apparatus according to any of claims 19 to 21 further comprising a liquid toner dispenser.
23. An electrophotographic imaging process comprising;
- (a) applying an electrical charge to a surface of an organophotoreceptor comprising an electrically conductive substrate and a photoconductive element on the electrically conductive substrate, the photoconductive element comprising
 - (i) a charge transport material as defined in any of claims 1 to 15; and
 - (ii) a charge generating compound.
 - (b) imagewise exposing the surface of the organophotoreceptor to radiation to dissipate charge in selected areas and thereby form a pattern of charged and uncharged areas on the surface;
 - (c) contacting the surface with a toner to create a toned image; and
 - (d) transferring the toned image to substrate.
24. An electrophotographic imaging process according to claim 23 wherein the photoconductive element further comprises a second charge transport material.
25. An electrophotographic imaging process according to claim 24 wherein the second charge transport material comprises an electron transport compound.
26. An electrophotographic imaging process according to any of claims 23 to 25 wherein the photoconductive element further comprises a binder.
27. An electrophotographic imaging process according to any of claims 23 to 26 wherein the toner comprises a liquid toner comprising a dispersion of colorant particles in an organic liquid.
28. A charge transport material having the formula



where Y_1 and Y_2 are, each independently, a bond, $-CR_1=N-NR_2-$, or $-CR_3=N-N=CR_4-$ where R_1 , R_2 , R_3 , and

R_4 comprise, each independently, H, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

X_1 and X_2 are, each independently, a linking group having the formula $-(CH_2)_m-$, branched or linear, where m is an integer between 0 and 20, inclusive, and one or more of the methylene groups is optionally replaced by O, S, C=O, O=S=O, a heterocyclic group, an aromatic group, urethane, urea, an ester group, an NR_5 group, a

CHR_6 group, or a CR_7R_8 group where R_5 , R_6 , R_7 , and R_8 comprise, each independently, H, hydroxyl group, thiol group, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

T_1 and T_2 are, each independently, a thiiranyl group, H, an alkyl group, an alkenyl group, or an aromatic group with the proviso that at least one of T_1 and T_2 is a thiiranyl group; and

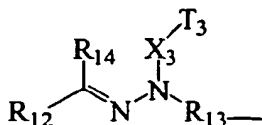
Ar comprises an aromatic group with the proviso that when both Y_1 and Y_2 are a bond and one of T_1 and T_2 is not a thiiranyl group, Ar comprises a bis[(N,N-disubstituted)amino] aromatic group or a bicarbazole group.

29. A charge transport material according to claim 28 wherein T_2 is H, the m value for X_2 is 0, Y_2 is a bond, Y_1 is $-CR_1=N-NR_2-$ where the C atom is connected to Ar and the terminal N atom is connected to X_1 , and T_1 comprises a thiiranyl group.

30. A charge transport material according to claim 29 wherein Ar comprises an arylamine group or an aromatic heterocyclic group.

31. A charge transport material according to either of claims 29 and 30 wherein R_2 comprises an aromatic group.

32. A charge transport material according to claim 31 wherein the aromatic group of R_2 has the formula



where R_{12} comprises an arylamine group, R_{13} is a linking group comprising an alkyl group, an alkenyl group, or an aryl group, R_{14} comprises H, an alkyl group, an alkenyl group, or an aryl group, X_3 has the formula $-(CH_2)_m-$, branched or linear, where m is an integer between 1 and 20, and T_3 is a thiiranyl group.

33. A charge transport material according to claim 28 wherein the m value for X_1 is 0, T_1 comprises an aromatic group, T_2 comprises a thiiranyl group, Y_2 is a bond, and Y_1 is $-CR_1=N-NR_2-$ where the C atom is connected to Ar and the terminal N atom is connected directly to T_1 .

34. A charge transport material according to claim 33 wherein Ar comprises an arylamine group or an aromatic heterocyclic group.

35. A charge transport material according to claim 28 wherein T_2 is H, the m value for X_2 is 0, Y_2 is a bond, Y_1 is $-CR_3=N-N=CR_4-$, and T_1 comprises a thiiranyl group.

36. A charge transport material according to claim 35 wherein Ar comprises an arylamine group or an aromatic heterocyclic group.

37. A charge transport material according to claim 28 wherein Y_1 and Y_2 are a bond and Ar comprises a bis[(N,N-disubstituted)amino]arylene group.

38. A charge transport material according to claim 37 wherein T_2 is H, an alkyl group, an alkenyl group, or an aromatic group.

39. A charge transport material according to claim 28 wherein Y_1 and Y_2 are a bond, Ar comprises two arylamine groups.

40. A charge transport material according to claim 39 wherein Ar is a bicarbazole group.

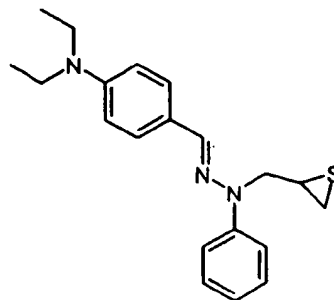
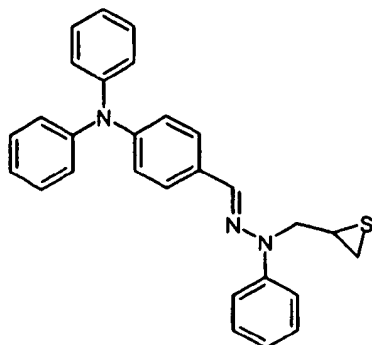
41. A charge transport material according to claim 28 wherein Ar comprises an arylamine group, Y_1 and Y_2 are each independently $-CR_1=N-NR_2-$, and T_1 and T_2 , each independently, comprise a thiiranyl group.

42. A charge transport material according to claim 28 wherein the charge transport material is selected from the group consisting of the following formulae:

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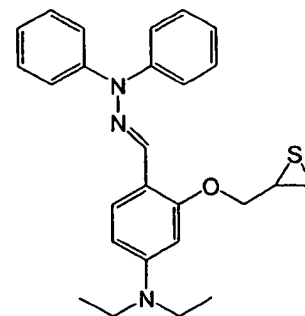
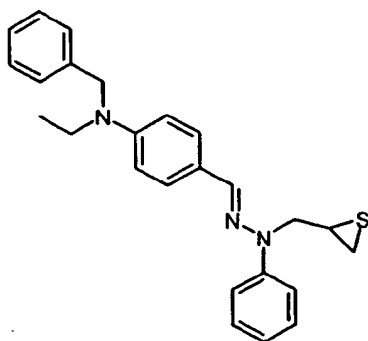
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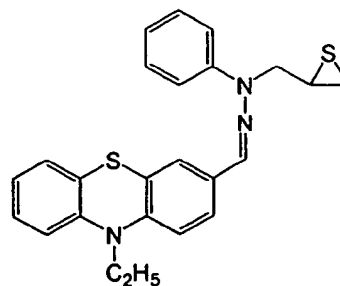
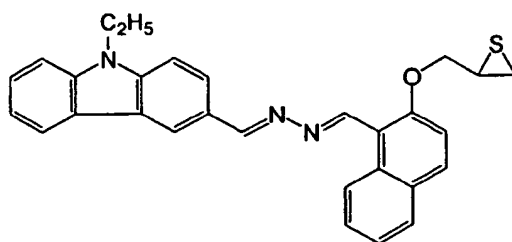
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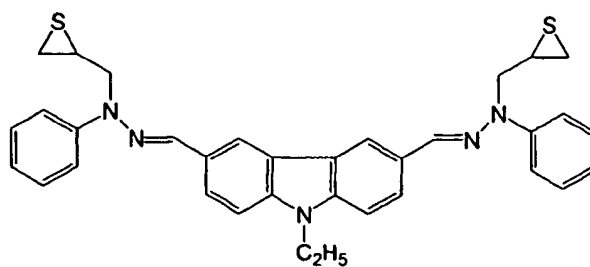
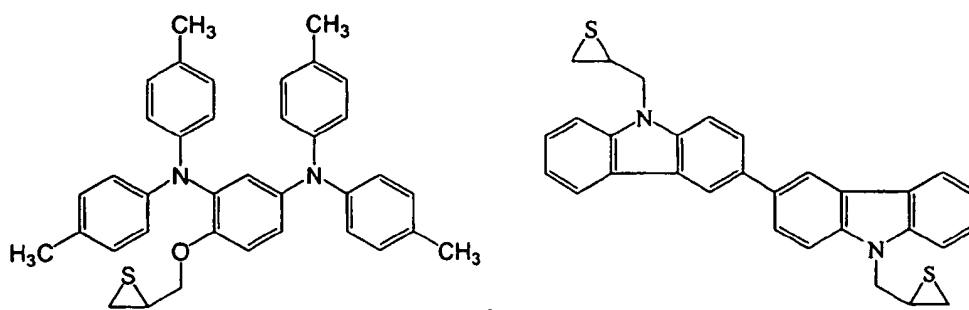
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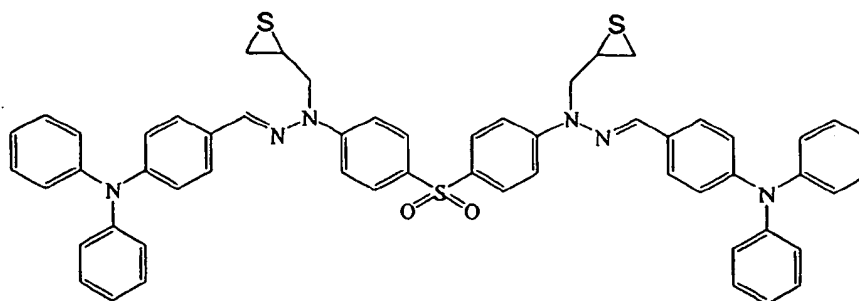


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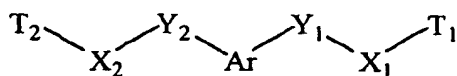
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and



43. A polymeric charge transport material prepared by the reaction of a functional group in a polymeric binder with at least a thiiranyl group in a compound having the formula



where Y_1 and Y_2 are, each independently, a bond, $-CR_1=N-NR_2-$, or $-CR_3=N=N-CR_4-$ where R_1 , R_2 , R_3 , and R_4 comprise, each independently, H, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

X_1 and X_2 are, each independently, a linking group having the formula $-(CH_2)_m-$, branched or linear, where m is an integer between 0 and 20, inclusive, and one or more of the methylene groups is optionally replaced by O, S, C=O, O=S=O, a heterocyclic group, an aromatic group, urethane, urea, an ester group, an NR_5 group, a CHR_6 group, or a CR_7R_8 group where R_5 , R_6 , R_7 , and R_8 comprise, each independently, H, hydroxyl group, thiol group, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

T_1 and T_2 are, each independently, a thiiranyl group, H, an alkyl group, an alkenyl group, or an aromatic group with the proviso that at least one of T_1 and T_2 is a thiiranyl group; and

Ar comprises an aromatic group with the proviso that when both Y_1 and Y_2 are a bond and one of T_1 and T_2

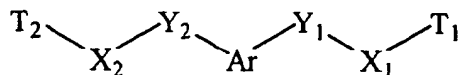
is not a thiiranyl group, Ar comprises a bis[(N,N-disubstituted)amino]aromatic group or a bicarbazole group.

44. A polymeric charge transport material according to claim 43 wherein the functional group of the binder is selected from the group consisting of hydroxyl group, carboxyl group, an amino group, and thiol group.

45. A polymeric charge transport material according to either of claims 43 and 44 wherein a crosslinking agent is bonded between the thiiranyl group and the functional group of the binder.

46. An organophotoreceptor comprising an electrically conductive substrate and a photoconductive element on the electrically conductive substrate, the photoconductive element comprising:

(a) a polymeric charge transport compound prepared by the reaction of a functional group in a polymeric binder with at least a thiiranyl group in a compound having the formula



where Y_1 and Y_2 are, each independently, a bond, $-CR_1=N-NR_2-$, or $-CR_3=N-N=CR_4-$ where R_1 , R_2 , R_3 , and R_4 comprise, each independently, H, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

X_1 and X_2 are, each independently, a linking group having the formula $-(CH_2)_m-$, branched or linear, where m is an integer between 0 and 20, inclusive, and one or more of the methylene groups is optionally replaced by O, S, C=O, O=S=O, a heterocyclic group, an aromatic group, urethane, urea, an ester group, an NR_5 group, a CHR_6 group, or a CR_7R_8 group where R_5 , R_6 , R_7 , and R_8 comprise, each independently, H, hydroxyl group, thiol group, an alkyl group, an alkenyl group, a heterocyclic group, or an aromatic group;

T_1 and T_2 are, each independently, a thiiranyl group, H, an alkyl group, an alkenyl group, or an aromatic group with the proviso that at least one of T_1 and T_2 is a thiiranyl group; and

Ar comprises an aromatic group with the proviso that when both Y_1 and Y_2 are a bond and one of T_1 and T_2 is not a thiiranyl group, Ar comprises a bis[(N,N-disubstituted)amino]arylene group or a bicarbazole group; and

(b) a charge generating compound.

47. An organophotoreceptor according to claim 46 wherein the photoconductive element further comprises an electron transport compound.

48. An organophotoreceptor according to either of claims 46 and 47 wherein the functional group of the binder is selected from the group consisting of hydroxyl group, carboxyl group, an amino group, and thiol group.



European Patent
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PARTIAL EUROPEAN SEARCH REPORT

Application Number

which under Rule 45 of the European Patent Convention EP 04 25 7403
shall be considered, for the purposes of subsequent
proceedings, as the European search report

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.7)
A	CHEMICAL ABSTRACTS, vol. 91, no. 14, 1979, Columbus, Ohio, US; abstract no.: 115374w, page 516 column 2 XP002324618 * abstract * & SU 672 604 A (KAUNAS POLYTECHNIC INSTITUTE) 12 July 1979 (1979-07-12) -----	1,5, 15-42	G03G5/06 C07D331/02 C07D409/12 C07D409/14 C07D417/12
A	CHEMICAL ABSTRACTS, vol. 98, no. 22, 1983, Columbus, Ohio, US; abstract no.: 189050d, page 600 column 1 XP002324619 * abstract * & SU 990 008 A (TOMSK POLYTECHNIC INSTITUTE) 23 February 1983 (1983-02-23) ----- -/-	1,28,43, 46	
			TECHNICAL FIELDS SEARCHED (Int.Cl.7)
			G03G C07D
INCOMPLETE SEARCH			
<p>The Search Division considers that the present application, or one or more of its claims, does/do not comply with the EPC to such an extent that a meaningful search into the state of the art cannot be carried out, or can only be carried out partially, for these claims.</p> <p>Claims searched completely :</p> <p>Claims searched incompletely :</p> <p>Claims not searched :</p> <p>Reason for the limitation of the search: see sheet C</p>			
Place of search The Hague		Date of completion of the search 14 April 2005	Examiner Francois, J
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document</p>			



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PARTIAL EUROPEAN SEARCH REPORT

Application Number
EP 04 25 7403

DOCUMENTS CONSIDERED TO BE RELEVANT			CLASSIFICATION OF THE APPLICATION (Int.Cl.7)
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	
A	V. ANDRULEVICIUTE ET AL.: "cationic photopolymerisation of carbazoly- and phenothiazinyl-containing thiiranes." JOURNAL OF PHOTOCHEMISTRY AND PHOTOBIOLOGY A: CHEMISTRY, vol. 147, 2002, pages 63-69, XP002324617 ELSEVIER * page 63 - page 67 *	1,5,15, 28,42	
A	CHEMICAL ABSTRACTS, vol. 77, no. 25, 1972, Columbus, Ohio, US; abstract no.: 164335d, TAKEDA,H.: "phenylglycidylether derivatives.VI." page 384 XP002324620 * abstract * & YAKUGAKU ZASSHI, vol. 92, no. 9, 1972, pages 1117-1123, JAPAN	1,15,28	TECHNICAL FIELDS SEARCHED (Int.Cl.7)
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European Patent
Office

INCOMPLETE SEARCH
SHEET C

Application Number

EP 04 25 7403

Claim(s) searched completely:
15,42

Claim(s) searched incompletely:
1-14,16-41,43-48

Claim(s) not searched:
-

Reason for the limitation of the search:

Present claims 1-14,16-41,43-48 relate to an extremely large number of possible compounds. In fact, the claims contain so many options, variables, that a lack of clarity (and conciseness) within the meaning of Article 84 EPC arises to such an extent as to render a meaningful search of the claims impossible. Consequently, the search has been carried out for those parts of the application which do appear to be clear (and concise), namely all thienylalkyl hydrazones, all thienylalkyl-aryl ethers and all N-thienylmethycarbazoles falling under the formula of claim 28.

**ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.**

EP 04 25 7403

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.
The members are as contained in the European Patent Office EDP file on
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14-04-2005

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